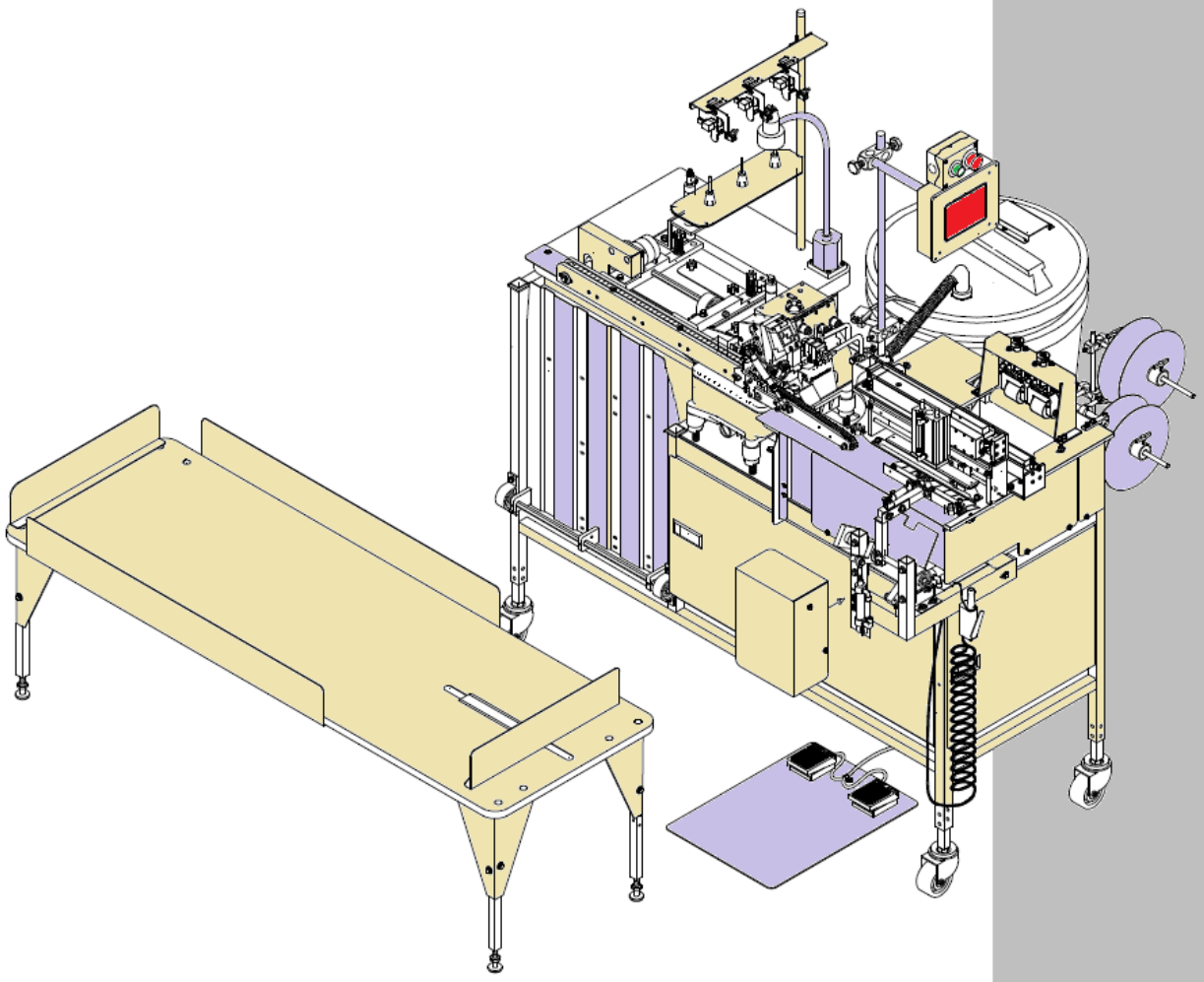
Model **1996B-ES**

Revision 2 Updated March 21, 2024(wr)

Instruction Manual



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Atlanta Attachment Company, Inc.

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IMPORTANT
It is important to read and understand the information contained within this manual before attempting to operate the machine. Atlanta Attachment Co., Inc. shall not be held liable for damage resulting from misuse of the information presented within and reserves the right to change the information contained within, without prior notification.

Patents & Patents Pending

The sale of this product does not sell or otherwise transfer any license or other rights under any U.S. Patent or other corresponding foreign patent.

This equipment is manufactured under one or more of the following patents:
4,280,421 ● 4,432,294 ● 4,466,367 ● 4,644,883 ● 5,134,947 ● 5,159,889 ● 5,203,270 ● 5,373,798 ● 5,437,238 ● 5,522,332 ● 5,524,563 ● 5,562,060 ● 5,634,418 ● 5,647,293 ●5,657,711 ● 5,743,202 ● 5,865,135 ● 5,899,159 ● 5,915,319 ● 5,918,560 ● 5,924,376 ●5,979,345 ● 6,035,794 ● 6,055,921 ● 6,202,579 ● 6,279,869 ● 6,295,481 ● 6,494,225 ●6,523,488 ● 6,574,815 ● 6,802,271 ● 6,834,603 ● 6,968,794 ● 6,994,043 ● 7,543,364 ●7,574,788 ● 7,647,876 ● 7,735,439

Foreign Patents: 9-520,472 ● 0,537,323 ● 92,905,522.6 ● 96,936,922.2 ● 2,076,379 ● 2,084,055
Other U.S. and Foreign Patents Pending.

Contents

Safety Instruction

This part of the Instruction Material is provided for the safe use of your equipment. It contains important information to help work safely with the unit and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

Mandatory Information

All persons operating and/or working on the Workstation should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

The Instruction Material comprises:

- Safety information
- Operator Instructions
- Electrical and Pneumatic diagrams

And may also include.

- A list of recommended spare parts
- Instruction Manual(s) for components made by other manufacturers
- The layout and installation diagram containing information for installation

Intended Use

Our machines are designed and built in line with the state of the art and the accepted safety rules. However, all machines may endanger the life and limb of their users and/or third parties and be damaged or cause damage to other property, particularly if they are operated incorrectly or used for purposes other than those specified in the Instruction Manual.

Exclusion of Misuse

Non-conforming uses include, for example, using the equipment for something other than it was designed for, as well as operation without duly installed safety equipment. The risk rests exclusively with the end user.

Conforming use of the machine includes compliance with the technical data, information, and regulations in all parts of the complete Instruction Material, as well as compliance with the maintenance regulations. All local safety and accident prevention regulations must also be observed.

Liability

The machine should only be operated when in perfect working order, with due regard for safety and the potential dangers, as well as in accordance with the Instruction Material. Faults and malfunctions capable of impairing safety should be remedied immediately. We cannot accept any liability for personal injury or property damage due to operator errors or non-compliance with the safety instructions contained in this booklet. The risk rests exclusively with the end user.

The Instruction Material should always be kept near the machine so that it is accessible to all concerned.

The local, general, statutory, and other binding regulations on accident prevention and environmental protection must also be observed in addition to the Instruction Material. The operating staff must be instructed accordingly. This obligation also includes the handling of dangerous substances and provision/use of personal protective equipment.

The Instruction Material should be supplemented by instructions, including supervisory and notification duties with due regard for special operational features, such as the organization of work, work sequences, the personnel deployed, etc.
The personnel's awareness of the dangers and compliance with the safety regulations should be checked at irregular intervals.

Choice and Qualification of Personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work - either within the company, by our field staff or at our office - and who have not only been duly appointed and authorized but are also fully familiar with the local regulations. Work on the machine should only be carried out by skilled personnel, under the management and supervision of a duly qualified engineer.
This not only applies when the machine is used for production, but also for special work associated with its operation (start-up and maintenance), especially when it concerns work on the hydraulic or electrical systems, as well as on the software/serial bus system.

Training

Everyone working on or with the machine should be duly trained and informed with regard to correct use of the safety equipment, the foreseeable dangers which may arise during operation of the machine and the safety precautions to be taken. In addition, the personnel should be instructed to check all safety mechanisms at regular intervals.

Responsibilities

Clearly define exactly who is responsible for operating, setting-up, servicing and repairing the machine. Define the responsibilities of the machine operator and authorize him to refuse any instructions by third parties if they run contrary to the machine's safety. This applies in particular for the operators of machines linked to other equipment. Persons receiving training of any kind may only work on or with the machine under the constant supervision of an experienced operator. Note the minimum age limits permitted by law.

A Word to the Operator

The greatest danger inherent in our machines:
is that of fingers, hands or loose clothing being drawn into a machine by live, coasting or rotating tools or assemblies or of being cut by sharp tools or burned by hot elements.

Always be conscious of these dangers!

Safety Equipment on the Machines

All machines are delivered with safety equipment, which shall not be removed or bypassed during operation.

The correct functioning of safety equipment on machines and systems should be checked every day and before every new shift starts, after maintenance and repair work, when starting up for the first time and when restarting (e.g. after prolonged shutdowns).

If safety equipment has to be dismantled for setting-up, maintenance or repair work, such safety equipment shall be replaced and checked immediately upon completing the maintenance or repair work.
All protective mechanisms shall be fitted and fully operational whenever the machine is at a standstill or if it has been shut down for a longer period of time.

Damage

If any changes capable of impairing safety are observed in the machine or its mode of operation, such as malfunctions, faults or changes in the machine or tools, appropriate steps must be taken immediately, the machine switched off and a proper lockout tagout procedure followed. The machine should be examined for obvious damage and defects at least once per shift. Damage found shall be immediately remedied by a duly authorized person before resuming operation of machine.
The machine should only be operated when in perfect working order and when all protective mechanisms and safety equipment, such as detachable protective mechanisms, emergency STOP systems, etc. are in place and operational.

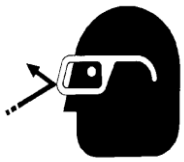
Faults or Errors

The machine must be switched off and all moving or rotating parts allowed to come to a standstill and secured against accidental restart before starting to remedy any faults or errors.

Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.
Clothing, Jewelry, Protective Equipment
Long loose hair, loose-fitting clothes, gloves, and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



Protective eyewear that has been tested by the local authorities should be worn whenever there is a possibility of loose or flying objects or particles such as when cleaning the machine with compressed air.

Tools

Always count the number of tools in your possession before starting work on the machine. This will allow you to check that no tools have been left behind inside the machine. Never leave a tool in the machine while working.

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

Smoking and open flame (e.g. welding work) should be prohibited in the production area due to the risk of fire and explosions.

Workplace

A clear working area without any obstructions whatsoever is essential for safe operation of the machine. The floor should be level and clean, without any waste.
The workplace should be well lit, either by the general lighting or by local lights.

Emergency STOP

The emergency STOP buttons bring all machine movements to a standstill. Make sure you know exactly where they are located and how they work. Try them out. Always ensure easy access to the nearest emergency STOP button while working on the machine.

First Aid

1. Keep calm even when injured.
2. Clear the operator from the danger zone. The decision of what to do and whether to seek additional assistance rests entirely with you, particularly if someone has been trapped.
3. Give First Aid. Special courses are offered by such organizations as the employers' liability insurance association. Your colleagues should be able to rely on you and vice versa.
4. Call an ambulance. Do you know the telephone numbers for the ambulance service, police and fire service?

Important Notices

Reporting and Fighting Fires

Read the instructions posted in the factory with regard to reporting fires and the emergency exits. Make sure you know exactly where the fire extinguishers and sprinkler systems are located and how they are operated. Pass on the corresponding information to the firemen when they arrive. Ensure there are enough signs to avoid fire hazards.

The following fire extinguishers may be used:
- Dry powder extinguishers, ABC fire-extinguishing powder.
- Carbon dioxide fire extinguishers to DIN 14461 for electronic components. Great care must be exercised when using carbon dioxide fire extinguishers in confined, badly ventilated rooms (see DIN 14406 and 14270).

Isolate the machine from the power supply if a fire breaks out. Do not use water on burning electrical parts until it is absolutely certain that they have been completely disconnected from the power supply. Burning oils, lubricants, plastics, and coatings on the machine can give off gases and vapors that may be harmful to your health.
A qualified person should be consulted to repair the damage after a fire.

Electrical Power Supply

Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.
In practice, this may mean that the technician, electrician, and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment. Energy sources (electrical/pneumatic/hydraulic, etc.) for the equipment shall be turned off or disconnected and the switches locked or labeled with a warning tag. It is the responsibility of the employer to establish control procedures. Follow lockout/tagout procedures before, setup and/or any service or maintenance work is performed, including lubrication, cleaning, or clearance of jams.

Caution: The machine is still not completely de-energized even when the master switch is off.

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.

- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected, and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.
- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

Delivery of the Machine/Packaging

Note any markings on the packaging, such as weights, lifting points and special information. Avoid temperature fluctuations. Condensation may damage the machine.

Transport Damage

The packaging and machine must immediately be examined for signs of damage in transit. Such damage must be reported to the shipper/transporter within the applicable time limits. Contact Atlanta Attachment Company and/or your transport insurer immediately, if signs of damage are visible. Never operate a damaged machine.

Interim Storage

If the machine has to be stored temporarily, it must be oiled or greased and stored in a dry place where it is protected from the weather in order to avoid damage. A corrosion-inhibiting coating should be applied if the machine has to be stored for a longer period of time and additional precautions taken to avoid corrosion.

Transporting the Machine

Disconnect the machine from all external connections and secure any loose assemblies or parts. Never step under a suspended load. When transporting the machine or assemblies in a crate, ensure that the ropes or arms of a forklift truck are positioned as close to the edge of the crate as possible. The center of gravity is not necessarily in the middle of the crate. Note the accident prevention regulations, safety instructions and local regulations governing transport of the machine and its assemblies.

Only use suitable transport vehicles, hoisting gear and load suspension devices that are in perfect working order and of adequate carrying capacity. Transport should only be entrusted to duly qualified personnel.

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.
All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.
Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.
Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.
Protect against unauthorized access.
Ensure that the machine and accessories are set up in a stable position.
Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

Particular attention must be paid to local and statutory regulations, etc. when installing machines and the plant (e.g. with regard to the specified escape routes). Note the safety zones in relation to adjacent machines.

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill, and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.
Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.
Retighten all screw connections that have to be loosened for the maintenance and repair work.
Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

The activities and intervals specified in the Instruction Manual for carrying out adjustments, maintenance and inspections must be observed, and parts replaced as specified.
All hydraulic and pneumatic lines should be examined for leaks, loose connections, rubbing and damage whenever the machine is serviced. Any defects found must be remedied immediately.

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard.
Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control.
When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

Replacement Parts
We cannot accept any liability whatsoever for damage due to the use of parts made by other manufacturers or due to unqualified repair or modification of the machine.

Repair, Electrical

The power supply must be switched off (master switch off) and secured so that it cannot be switched on again inadvertently before starting any work on live parts.
Those parts of the machine and plant on which inspection, maintenance or repair work is to be carried out must be isolated from the power supply, if specified. The isolated parts must first be checked to determine that they are truly de-energized before being grounded and short-circuited. Adjacent live parts must also be isolated.
The protective measures implemented (e.g. grounding resistance) must be tested before restarting the machine after all assembly or repair work on electric parts.
Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current rating.
The machine must be switched off immediately if a fault develops in the electrical power supply.
The electrical equipment of our machines must be checked at regular intervals and any defects found must be remedied immediately.
If it is necessary to carry out work on live parts, a second person should be on hand to operate the emergency OFF switch or master switch with voltage release in the event of an emergency. The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

Ventilation/Hazardous Gases

It is the end users responsibility to ensure adequate ventilation is provided to exhaust any and all noxious or hazardous gases that may be present in the working environment.
Hydraulic and Pneumatic Systems
Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge and experience of hydraulic systems. Pressure lines shall be depressurized before starting any repair work.

General Liability

Liability for machine damage and personal injury is extinguished completely if any unauthorized conversions or modifications are undertaken. The machine must not be modified, enlarged or converted in any way capable of affecting safety without the manufacturer's prior approval.

Starting Machine Movements

Read the Instruction Manual carefully to establish which keys and functions start machine movements.

A Word to the End User

The end user has sole responsibility to enforce the use of safety procedures and guards on the machine. Any other safety devices or procedures due to local regulations should be retrofitted in accordance to these regulations and/or the EC Directive on the safety of machines.
Operator’s position must always be readily accessible. Escape routes must always be kept clear and safety areas should be identified.

Safety Precautions

Safety should be a constant concern for everyone. Always be careful when working with this equipment. While normal safety precautions were taken in the design and manufacture of this equipment, there are some potential safety hazards.
Everyone involved with the operation and maintenance of this equipment should read and follow the instructions in this manual. Operate the equipment only as stated in this manual. Incorrect use could cause damage to the equipment or personal injury.

It is the owner's responsibility to make certain that the operator reads and understands this manual before operating this equipment. It is also the owner's responsibility to make certain that the operator is a qualified and physically able individual, properly trained in the operation of this equipment.

Specific safety warning decals are located on the equipment near the immediate areas of potential hazards. These decals should not be removed or obliterated. Replace them if they become non-readable.

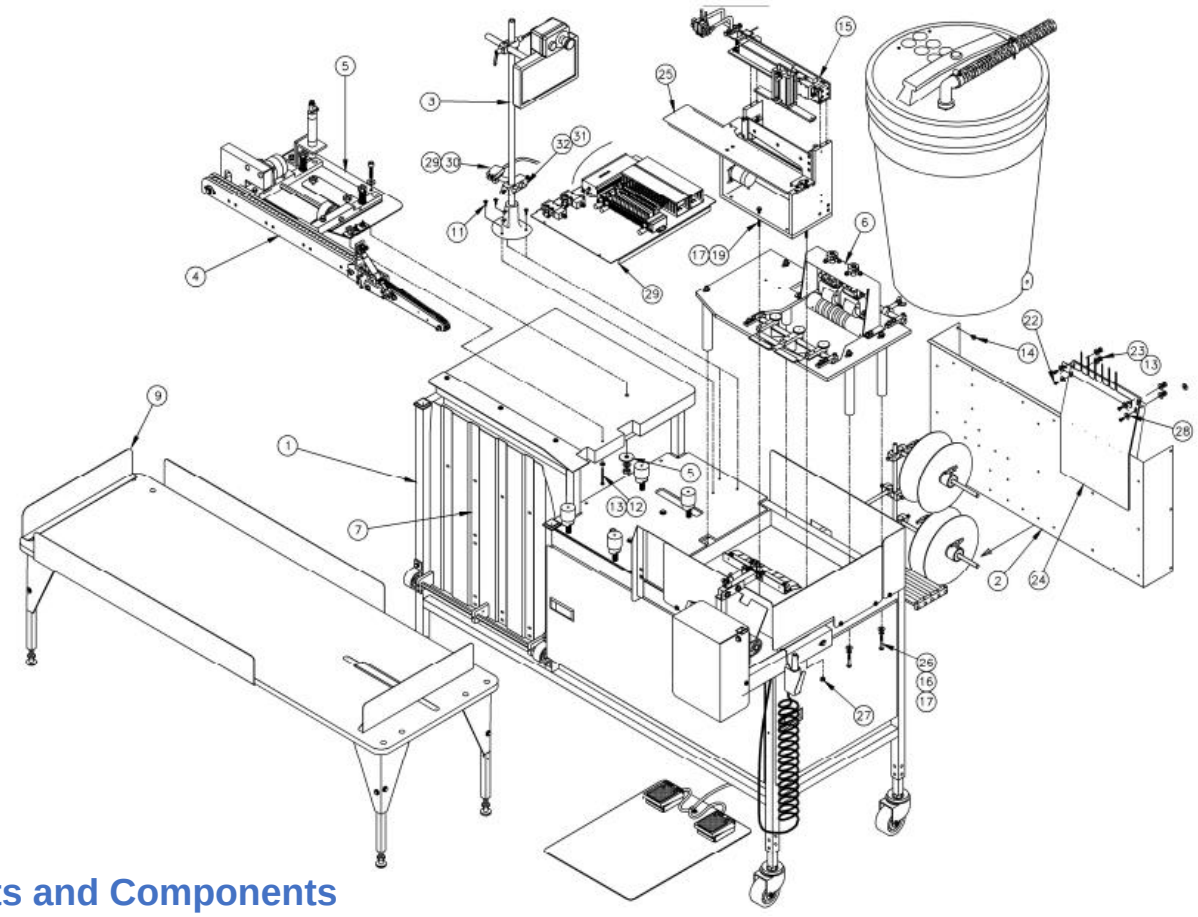
- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.

ALWAYS wear adequate eye protection when servicing the hydraulic system and battery.

- NEVER operate a poorly maintained machine.
- NEVER allow persons to operate this machine without proper instruction.
- NEVER put hands or feet under any part of the machine while it is running.
- NEVER attempt to make any adjustments or repairs to the machine while running. Repairs or maintenance should be performed by trained personnel only.
- NEVER work under the machine unless it is safely supported with stands, blocks or a hoist and blocks.
- NEVER touch hot parts of machine.

1. INSTALLATION

NOTE: It is important that the machine technician read this manual and is familiar with all the functions and safety concerns of the unit before Installing and operating.



Parts and Components

	Part Number	Description		Part Number	Description
1	1996-01D	Table Stand Motor	17	WWFS1/4	Washer, Flat
2	1996005	Electric Box Assy	18	1996B-PD	Diagram, Pneumatic
3	97-1700A	Control Box Assy	19	SSHC01192	Screw, Hex, 1/4-20 x 3
4	1996-05	Top Conveyor Assy	20	1996ES-WD	Diagram, wiring
5	1996-06	Conveyor MT Kit	21	SSTS98040	Screw, Truss, 10-32 x 5/8
6	1996-08B	Feed Assy	22	NNK10-32	Kep nut
7	1996-12	Stacker Door	23	1996-038	Plate, SLK Loop
8	1996010	Cable Package	24	1996-300A	Guillotine Assy
9	1996-15A	Indexing Table	25	SSHC01160	Screw, Hex, 1/4-20 x 2-1/2
10	1996-Label	Label Package	26	NNK1/4-20	Kep nut
11	SSFP01048	Screw, Phillips, 1/4-20 x 3/4	27	1996-23	Stripper Fingers
12	SSPS95128	screw, Pan Slotted, 10-24 x 2	28	1996007	Panel, Pneu Control
13	WWFS10	Washer	29	FFSM312LVQ	Photocell
14	SSZS93032	Screw, sheet metal 10-16 x 1/2	30	265155A	Holder, eye
15	1996-10B	Transfer Sub-assy	31	1740BB-43	Rod, straight
16	WWL1/4	Washer, 1/4 lock	32	28201	Rod, connector

Technical Data

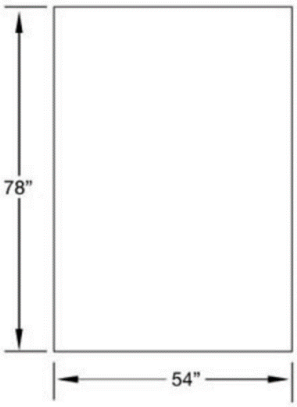
Voltage (v/ph/hz)	220v 1ph
Current (amps)	5
Air pressure (psi)	90
Air consumption (cfm)	10
Shipping weight (lbs)	1100
Shipping dimensions (w/l/h, inch)	96 x 55 x 60

Production: Approximately 487 pieces per hour. Estimate based on cycle time, material changeover, and machine program time.
Cycle time: Approx. 17" (43.2 cm) strip - .066 min 30" (76.2 cm) strip .086 min
Changeover time: Approx. 30 seconds, by the operator
Capacity: Width minimum 2" (5.08 cm) to 8" (20.32 cm) roll or 4"(dual roll).
Band Length: 15" (38.1 cm) to 52" (132 cm) (7 1/2" (19.05 cm) to 26" (66.04 cm) folded)
Seamer: Yamato 8003 3 thread (504 stitch)
Controls trim-off: 1/4" (6.4 mm) o 1/8" (3.2 mm)
Cut length: Programmable in 1/10" increments

Tolerances
Alignment: Side +/-1/16" (1.2mm), Ends +/-1/16" (1.2mm),
Length Repeatability:+/-1/8" (3.2 mm) (rib knit). Length Is Adjustable to Nearest 1/10 (2,5mm)
Cutting Accuracy: Within 1/8" (3.2 mm) of programmed length
Seam ply alignment: Within 1/8" (3.2 mm) obtainable

Footprint

Machine footprint is 78" x 54" (198x137 cm) Leave enough free space around to be able to open all doors and have access for maintenance.

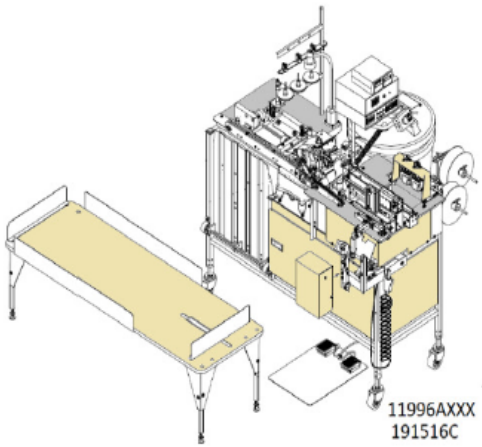


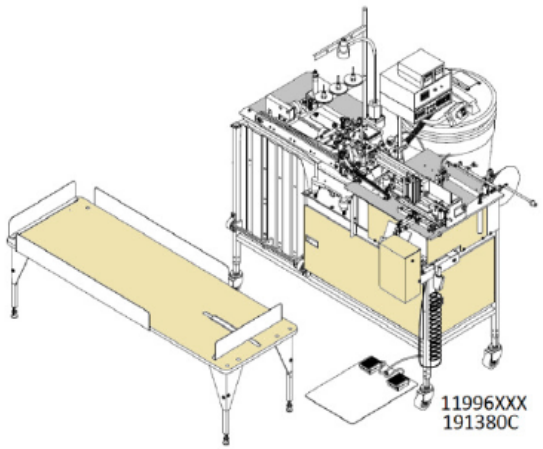
Machine Identification Label

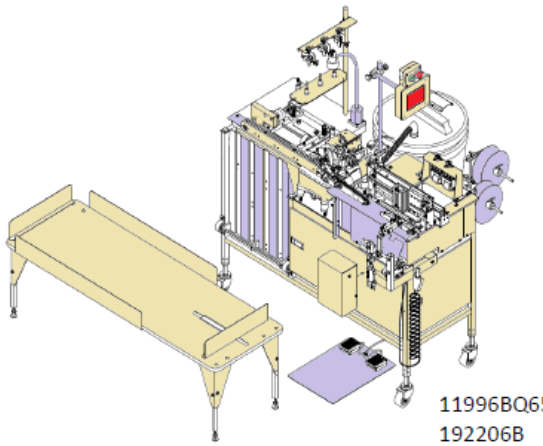
Machine identification is located on top of the table behind the sewing head. Its contents are the machine class and the Serial Number. Ex: 218427031707
Serial number is divided as follow.
First number identify the order number 218427
Next number month of manufacturing (03)
Next number the year of manufacturing (17)
Following a correlative number 07

1966 Automatic Cuff, Collar, and Waistband Workstation

	Part Number	Description	Sewing Head (XXX)				Motor		Rolls		Drawing
			Pegasus	Yamato	Juki	Rimoldi	Panasonic	Efka	Single	Double	
*	11996BQ65ES	Auto Cuff, Collar and Waistband Workstation, W/Cutter, SBUS, JUKI 6916S, Efka DC1500			X			X			192206B
	11996G61	AUTO COLLAR & BAND EX5204 PEGASUS	X								
	11996G61A	AUTO COLLAR & BAND, PANA EX5204 PEGASUS	X				X				
	11996CG61	AUTO COLLAR & BAND, PANA GUILLOTINE, S/R, PEGASUS	X				X		X		
	11996CG61A	AUTO COLLAR & BAND, PANA GUILLOTINE, S/R, PEGASUS	X				X		X		
	11996BG61A	AUTO COLLAR & BAND, PANA GUILLOTINE, D/R, PEGASUS	X				X			X	
	11996AY23	AUTO COLLAR & BAND, PANA DUAL ROLL SET-UP, 8003 YAM		X						X	191516C
	11996Y23	AUTO COLLAR & BAND 8003 YAMATO HEAD		X							191380C
	11996CY23	AUTO COLLAR & BAND GUILLOTINE, S/R, YAMATO		X					X		
	11996BY52	AUTO COLLAR & BAND, PANA GUILLOTINE, D/R, 8003G YAM		X			X			X	
	11996BJ95	Automatic Cuff, Collar and WaiStband Workstation, with Guillotine Cutter, Juki 3904 Sewing Head			X					X	
	11996AJ95	AUTO COLLAR & BAND, PANA DUAL ROLL, 3904 JUKI 8003			X		X			X	191516C
	11996R33	AUTO COLLAR & BAND F27-00-1CD-07 RIMOLDI				X					191380C
	11996BR33	AUTO COLLAR & BAND, PANA GUILLOTINE, D/R, RIMOLDI				X	X			X	
	11996AR33	AUTO COLLAR & BAND, PANA DUAL ROLL SET-UP, RIMOLDI				X	X			X	191516C
	11996CR33	AUTO COLLAR & BAND, PANA GUILLOTINE, S/R, RIMOLDI				X	X		X		







Assembly

1. Remove all shipping straps from machine.
2. Inspect the machine for any damage that may have occurred during shipping. If damage is found, report this immediately to your supervisor. Document the damage and provide details and photographs.
3. Position the machine in a desired location on a sound and reasonably level floor. Make sure that there is sufficient lighting over the machine. Remove all packing material.
4. Apply with a clean towel a light coat of oil to all black oxide parts to avoid future corrosion.

1. Wheels

After removing machine from crate remove transportation plates and install all 4 wheels on the unit

2. V-belt

If sewing head was removed before shipping, reinstall sewing head and check V-belt tension.

3. Sewing Head Lubrication

Oil may be removed before shipping. Prior to using refill and check the oil level in sewing heads. (ISO Viscosity Grade 22 part #)

Check that the oil level is in the operating range.

4. Thread Stand

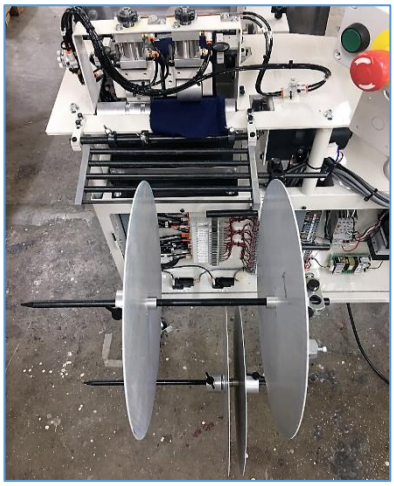
Install thread stand according to the picture.

5. Roll Holders

Install roll holders brackets according to picture A. For Collars operations use configuration B, for Waistbands operations use configuration C

A

B



C

6. Waste System

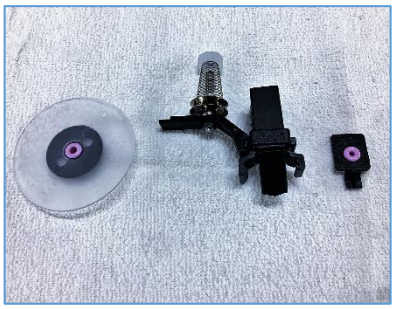
Connect the waste tubes.

7. Stacker

Install Stacker and connect according to the pictures.

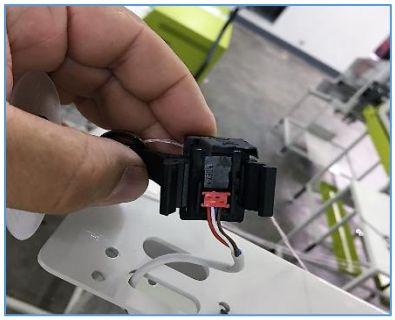
8. Thread Detectors (Inductive)

- Assemble all thread detectors according to the pictures

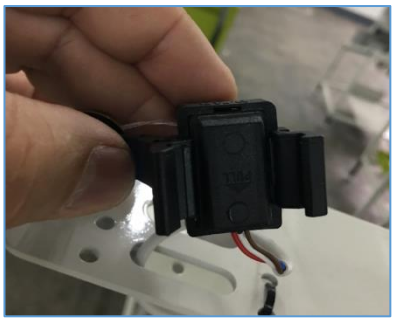


- Connect thread detector to the unit following steps A to F

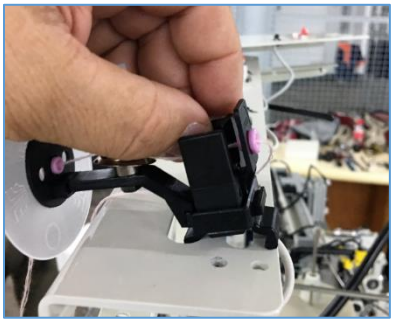
A



B

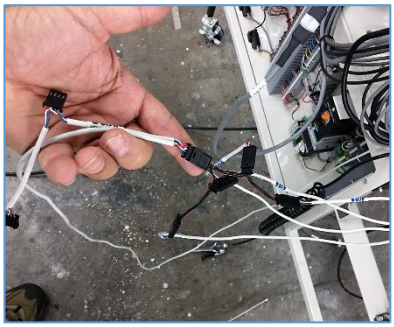


C



D

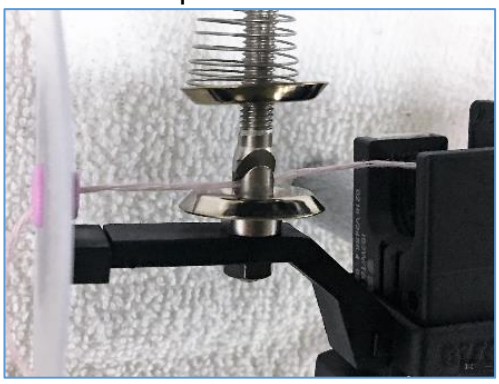
E



F

- Pass thread through detector picture A and the slot on the tension post as shown on B.

A

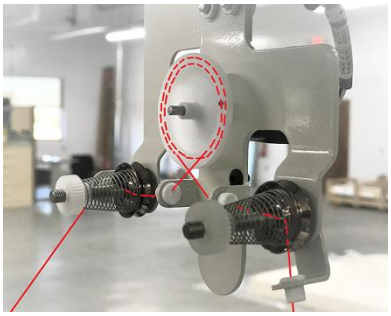


B

9. Thread Detectors (Encoder)

- Plug the thread detector to the unit

- Pass thread through detector wheel twice and the slot on both of the tension post as shown



10. Touch Screen Controller

Install Touch Screen. (Serial Bus)

11. Stepping Motors

Press “JOG” buttons and check function of all stepping motors.

12. Air Supply

Connect air supply. Requires one 3/8" air supply.
Set to 80 psi (6Bar)
Air consumption is 10 CSM

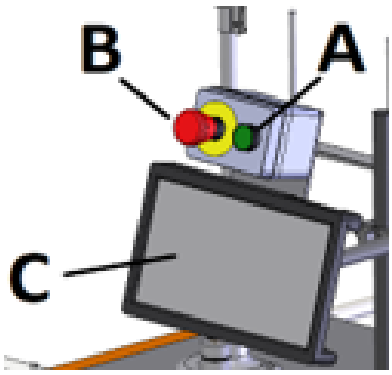
13. Power Connection

Wire the power cord to 208-230vac, single phase. 5 Amp.

NOTE: It is important that the green wire should be connected to earth ground.

14. Power "ON"

Twist the Emergency Stop Red button "B" to return to its normal position.



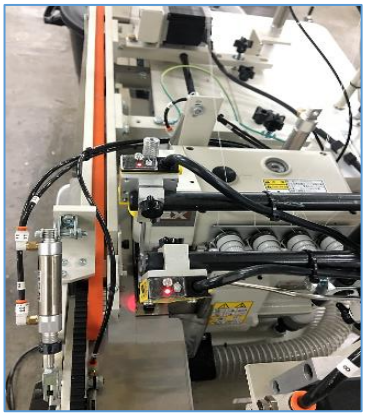
Turn the machine "ON" by pressing the green button "A" on the box just above the touch screen.

The machine will first display the language choices and after several seconds its show the "`1996 BAND MACHINE" screen.

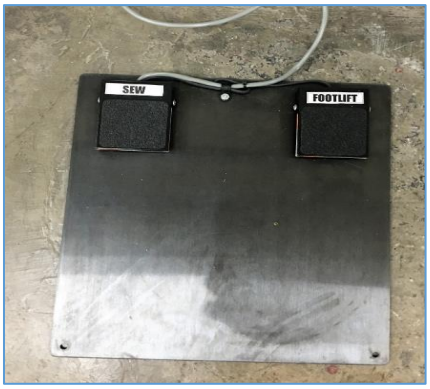
This screen is the one that the operator will always see upon power up

15. Electric Eyes

With power on, examine all 5 electric eyes and ensure they are all adjusted and functioning properly. When the eye is seeing the reflective tape, the red LED under the plastic cover at the rear should be on. See service section for instructions if required



16. Sewing Pedal



Rotate the sewing head hand wheel by hand and check for freedom of movement. Hand wheel rotation should already be set. Test sewing with SEW pedal (left pedal) on a piece of scrap material. Press CUTBAND on the main control board to cut thread chain if required

17. Foot lift Pedal

Step on FOOTLIFT Pedal (right pedal) to verify proper function of Foot lift.

Interim Storage

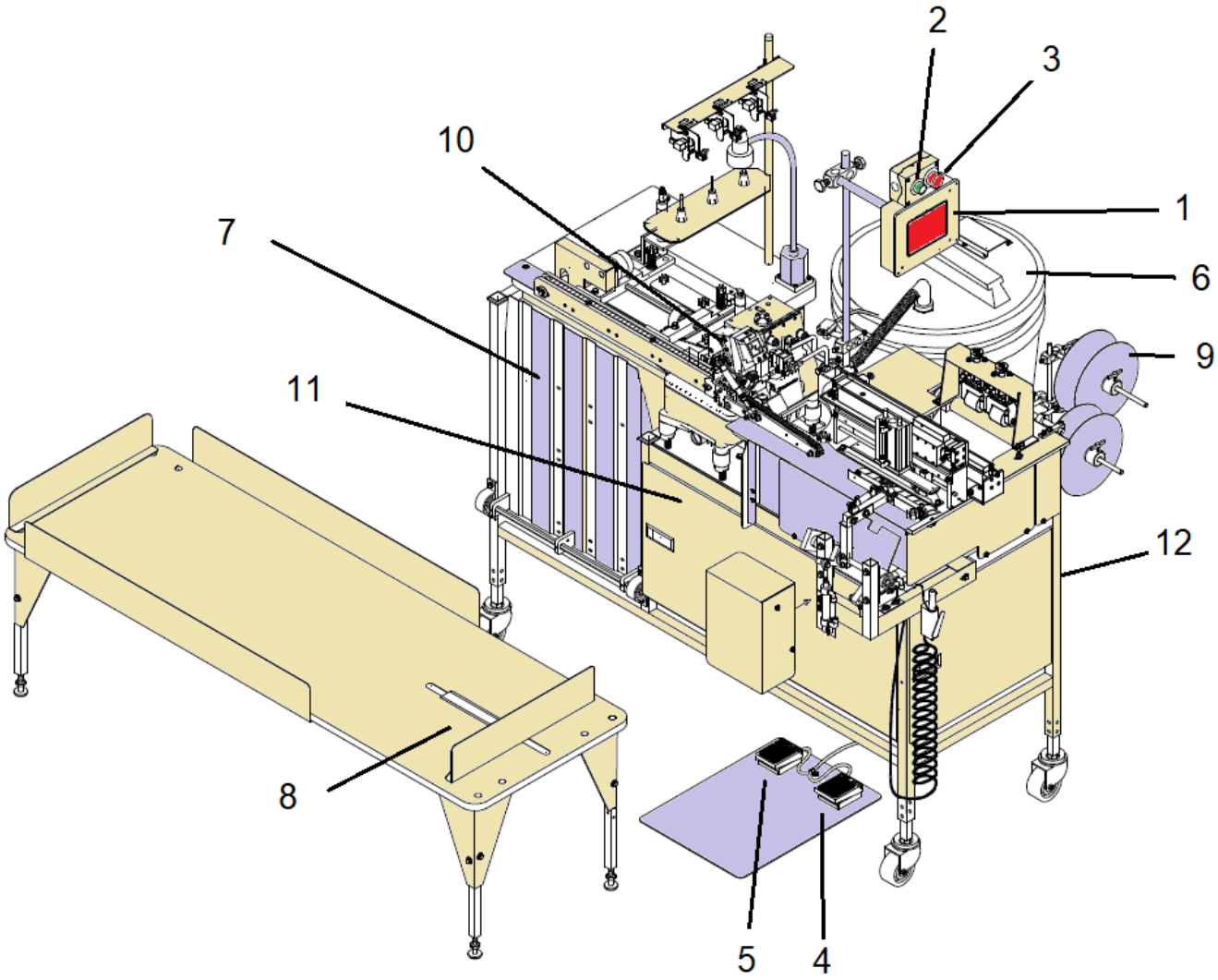
If the machine has to be stored temporarily, it must be oiled or greased and stored in a dry place where it is protected from the weather in order to avoid damage. A corrosion-inhibiting coating should be applied if the machine has to be stored for a longer period of time and additional precautions taken to avoid corrosion.

2. OPERATION

Note: It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

Operation Mode

Individual Components

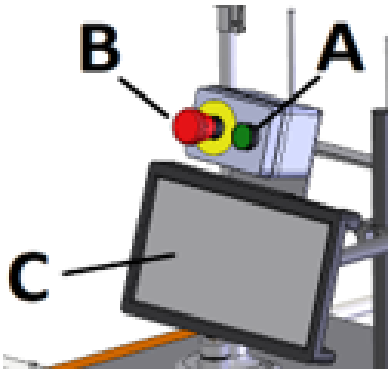


1.- Serial Bus	7.- Stacker
2.- Power On button	8.- Indexer
3.- Emergency Stop	9.- Roll Holders
4.- Foot lift Pedal	10.- Sewing Head
5.- Sew Pedal	11.- Sewing Motor
6.- Waste System	12.- Stepper box

Serial Bus

Controls all machine functions. More details are available in related chapters in this manual
The Control Panel “C” allows the operator to start and stop the automatic function of the machine, shut off power to the machine in the event of an emergency.

Caution: Unlocking the button with the Power “ON” engaged will turn on power to the machine.



1. Power On

Power the machine **“ON”.(A)**

2. Emergency Stop

Pressing this button will turn off power to the machine. This button will lock when pressed. Twisting the button will cause it to unlock and return to its normal position.
Pressing this button will turn off power to the machine. This button will lock when pressed.

3. Foot lift Pedal

This pedal will raise the presser foot.

4. Sew Pedal

Activating this pedal will run the sewing machine and disable the automatic functions.

5. Waste System

The system only runs while sewing to reduce air consumption. Has filtered waste container to trap lint. It needs to be cleaned every day. See maintenance section on this manual.

6. Stacker

The stacker operates after each band is sewn and moved to the stack position. Each stack cycle increments the piece per bundle counter.

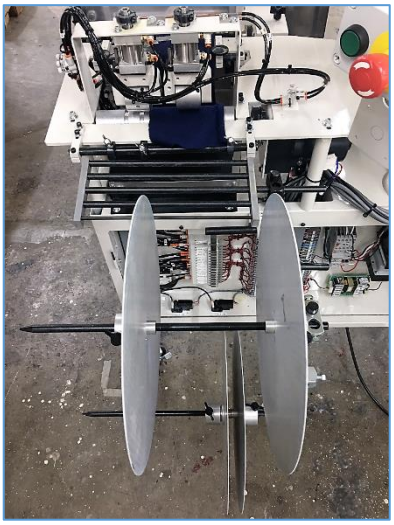
7. Indexer

When the desired quantity for the bundle is reached, the index table will move the stack out of the way, increment the bundles counter, and reset the pieces per bundle counter to 0.

8. Roll Holders

For Collars operations use configuration B, for Waistbands operations use configuration C

B



C

9. Sewing Head

Units can be supply with different Sewing heads. Refer to the sewing head manufacturer for detailed instructions.

10. Motors

Units can be supply with 2 different motor types.

a. Efka

The control box is located inside the right door under the machine. It has an On/Off switch which should remain in the “ON” position at all times. The sewing head is controlled by this box.

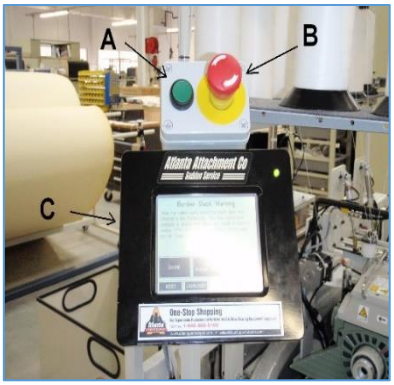
b. Panasonic

It is located inside the right door under the sewing machine (A)., The sewing head is controlled by this box.

c. Stepper Control Box

Touchscreen

General Operation



Twist the Emergency Stop Red button “B” to return to its normal position. Turn the machine “ON” by pressing the green button “A” on the box just above the touch screen. The machine will first display the language choices and after several seconds its show the “MAIN READY” screen. This screen is the one that the operator will always see upon power up

Caution: Do Not Use Any Sharp Objects to Touch the Screen

The graphics images presented on the touch screen show "3-dimensional" buttons, which may be pressed to access other screens, change counters and timers, or actuate hardware. Areas lacking the "3- dimensional" border contain information only.
The row of buttons across the bottom of the screen are called Standard buttons. They will appear or change based on the needs of the current screen

RESET: Always brings the machine back to its original power up state.

LANGUAGE: Return to the language screen. You can select multiple languages to use.

HOME: Leaves the current screen and takes you to an appropriate screen (usually to the main operating screen). Return to the main screen

CLOCK: Lower right button allows access to a screen for setting the correct time. While on the Main Screen it allows you to set the time and date. On all other screens it is a display only.

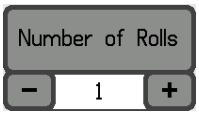
EXIT: Leaves the current screen and takes you to an appropriate screen (usually back one level or to the previous screen you were on.

CONTINUE: Used to restart an event or function that has been temporarily paused or suspended.

Other buttons are localized on top of or inside the screen

ARROWS: Pressing the arrows right or left will take you to the next or previous pages.

COUNTERS: Are identified with the "+" and "-" buttons in the corners. These counters may be adjusted by touching the "+" and "-" boxes.



NOTES: When a button has a white background, the function is “ON” or enabled. A dark background indicates off or disabled. Some buttons may toggle ON or OFF, others must be held in the ON state.

Other screens display whenever there is a machine error or other condition that prohibits the operation of the machine. Simply follow the instruction on the screens to resolve the problem. There are also advanced settings and advance functions available. These functions are only accessible by a password, and include timers that control machine hardware, input and output test screens, and machine statistics. To get to the advanced functions the appropriate password must be entered at the security screen. Security access is reset whenever the main power is turned off, or the RESET button on the main page is pressed.

Available Menus

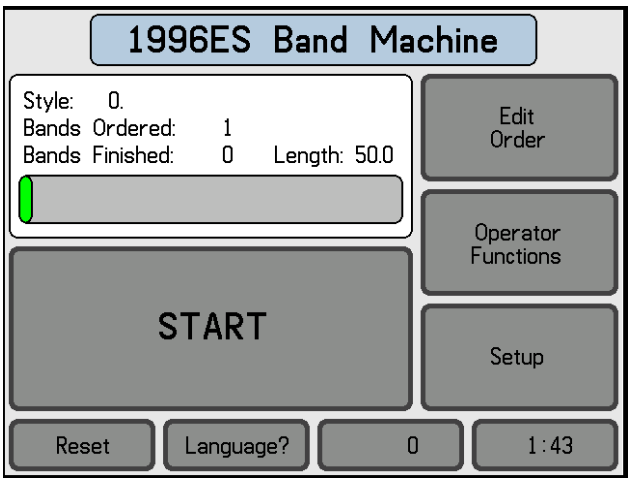
The following is a summary of the different screens and their functions available for the Sewing Operator.

1. START SCREEN.

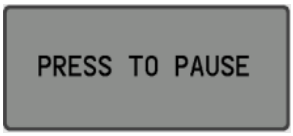
It is the main screen. Machine will run after loading the material

START

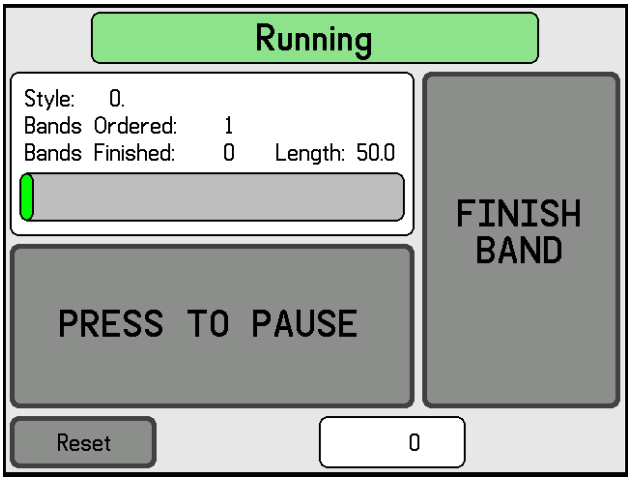
Normal operation of machine begins



PRESS TO PAUSE



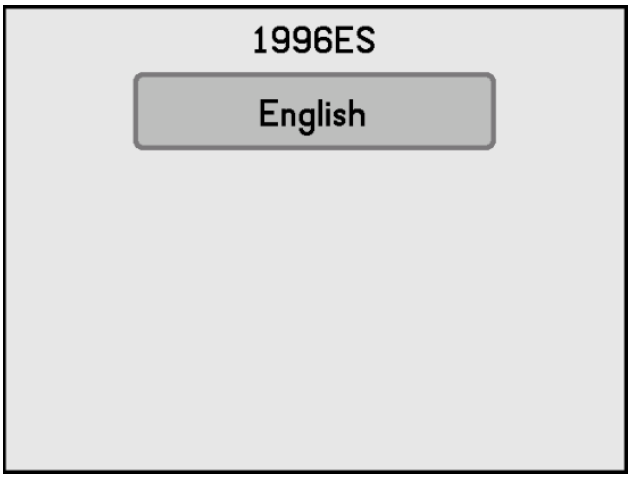
Machine functions will be paused



FINISH BAND

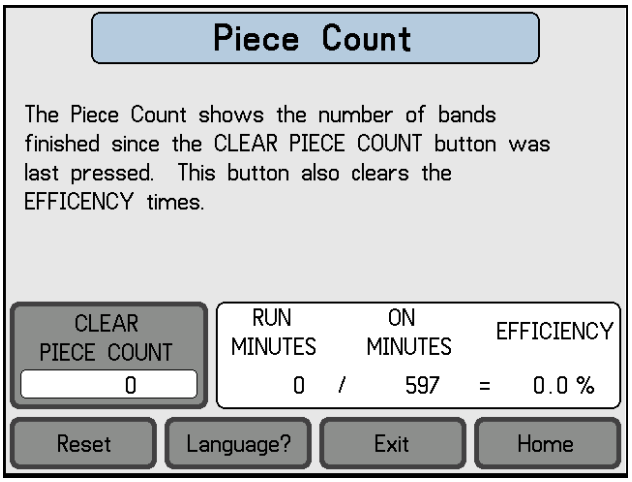
Machine functions will resume

LANGUAGE



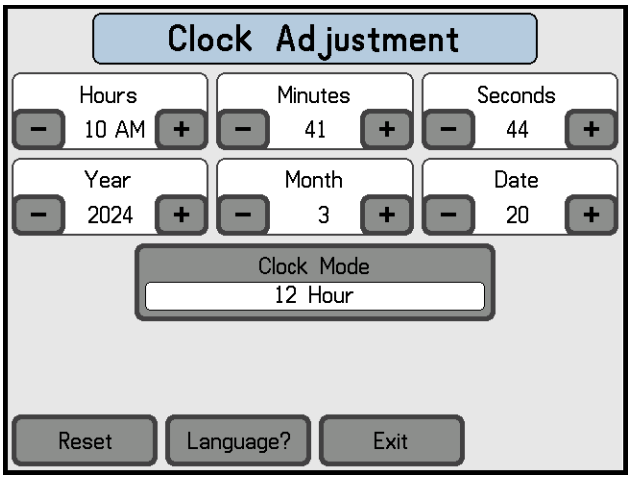
PIECE COUNT

The Piece Count shows the number of bands finished since the CLEAR PIECE COUNT button was last pressed. This button also clears the EFFICENCY times.



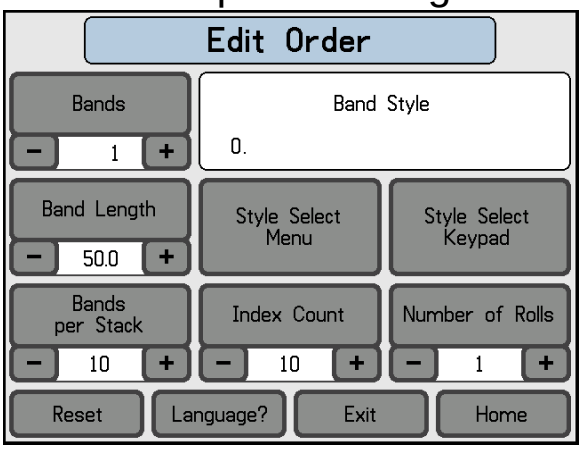
CLOCK

Sets current time and date.

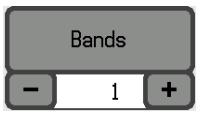


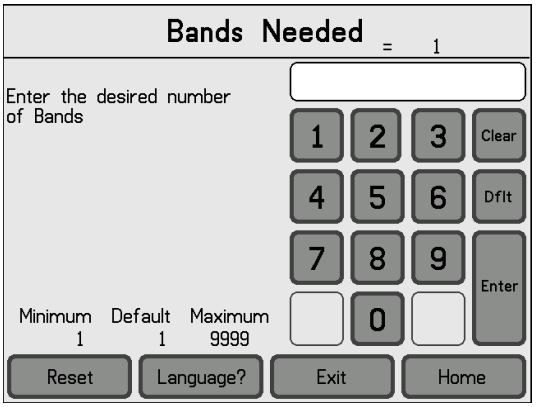
2. EDIT ORDER

Input of changes

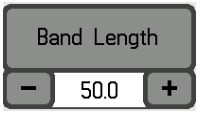


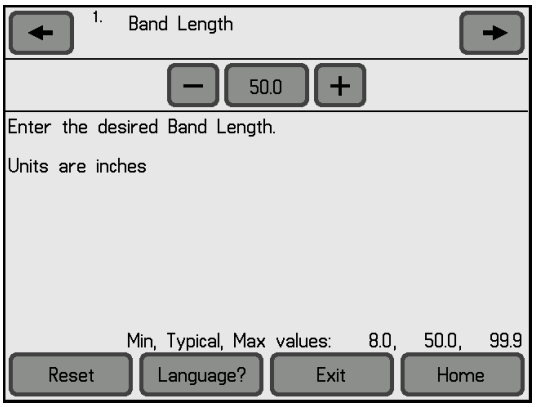
BANDS



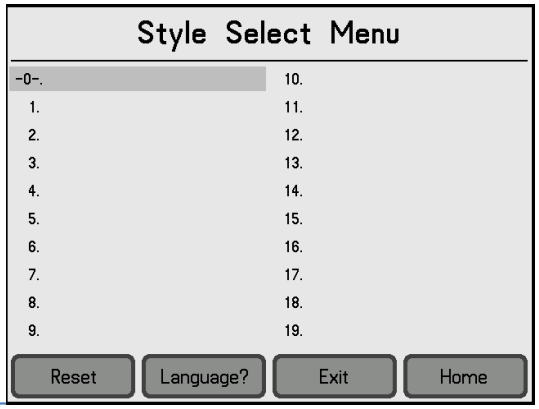


BAND LENGTH

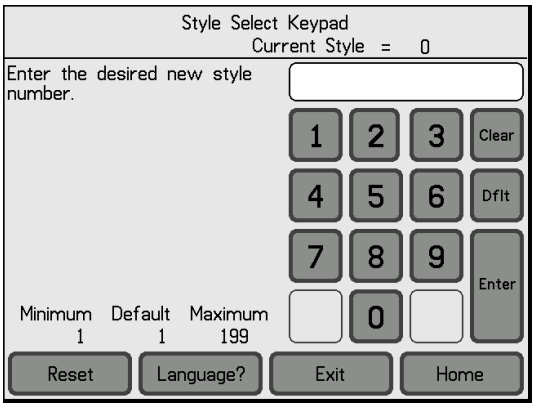




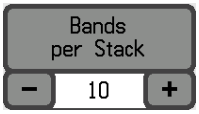
STYLE SELECT MENU

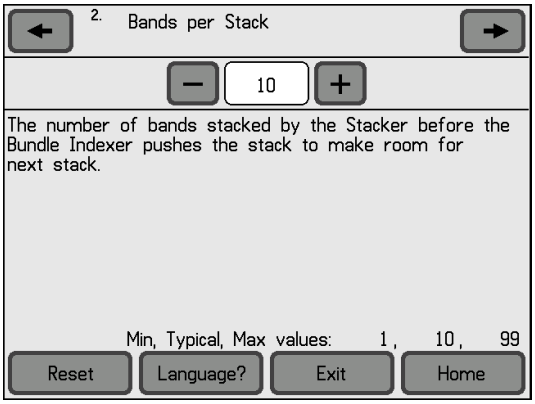


STYLE SELECT KEYPAD

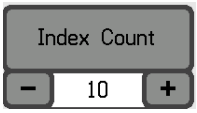


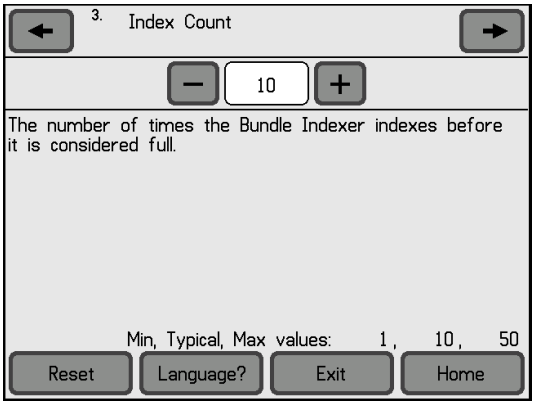
BANDS per STACK



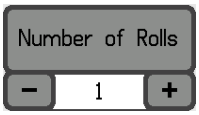


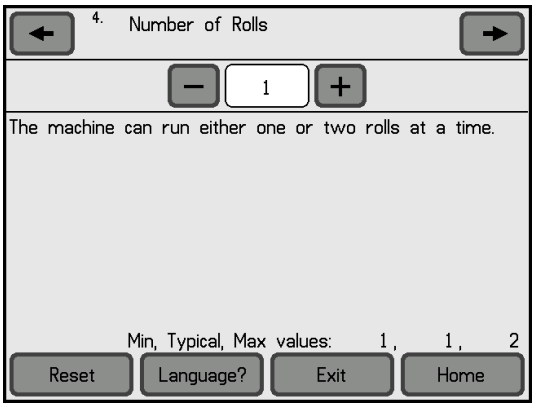
INDEX COUNT





NUMBER of ROLLS

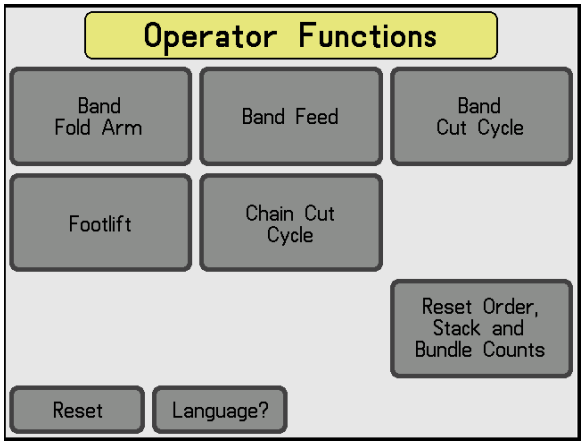




3. OPERATOR FUNCTIONS

Operator will be able to manually activate some machine functions.

To RESUME normal operation reset needs to be pressed



BAND FOLD ARM

Cycle of folding assembly

BAND FEED

Manually feed band material

BAND CUT CYCLE

Manually cut band material

FOOTLIFT

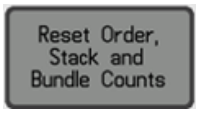
Manually raise foot on sewing head

CHAIN CUT CYCLE

Manually cut sewing chain

RESET ORDER STACK AND BUNDLE CLAMPS

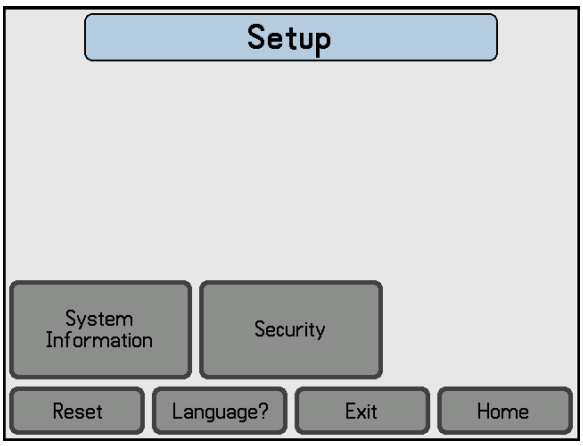
Reset of functions



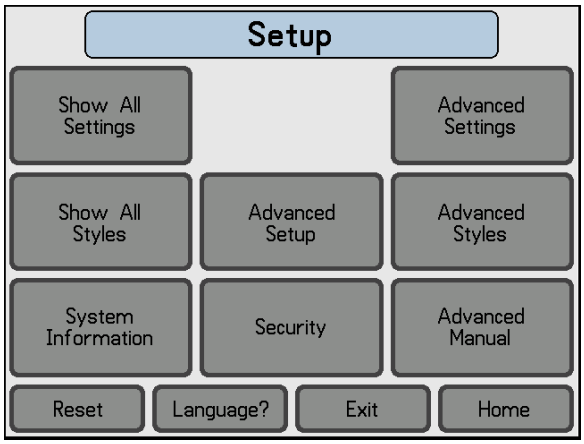
4. SETUP

These screens will show up every time the pedal is activated, or the setup button is pushed.

OPERATOR LEVEL SETUP



MECHANIC LEVEL SETUP



See Technical Screens in Service Section for more details on Mechanic Level Setup Functions

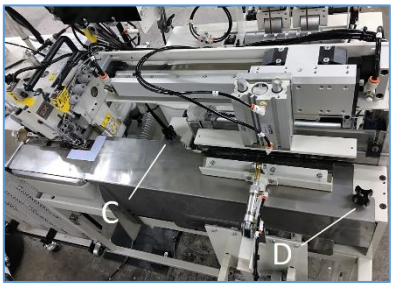
To **Reset**, **Exit** (Go-back) or return to **Home** screen, push one of these buttons.

Pre-Sewing

1. Cover removing.

a. Release nut **“A”** and Remove feeding belt from the sewing Area.

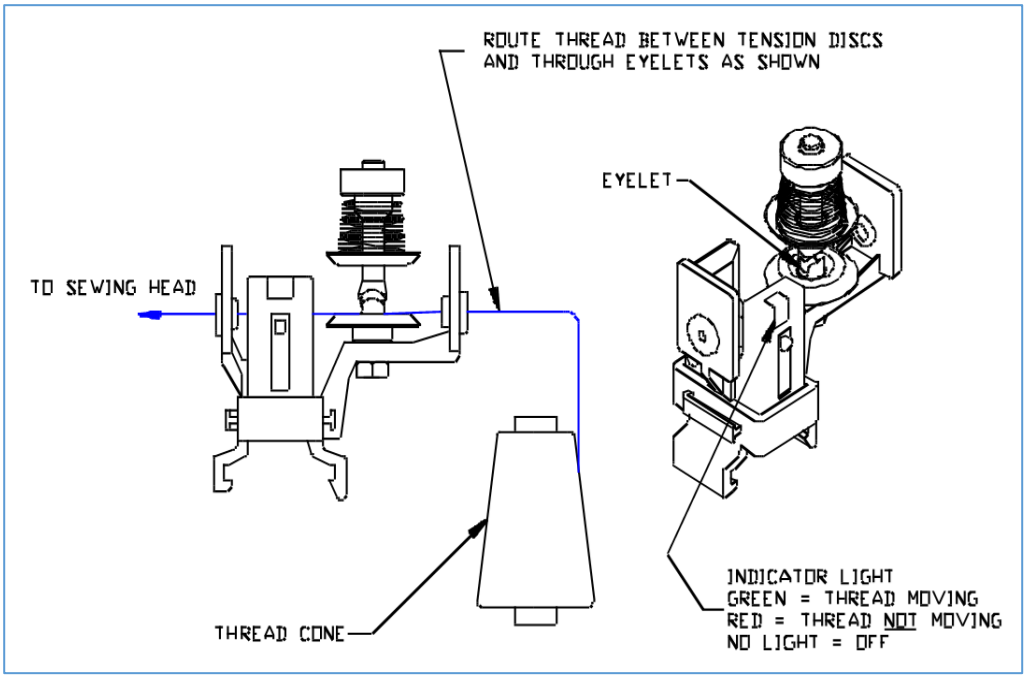
b. Release Nut **“C”** & **“D”** and remove plate

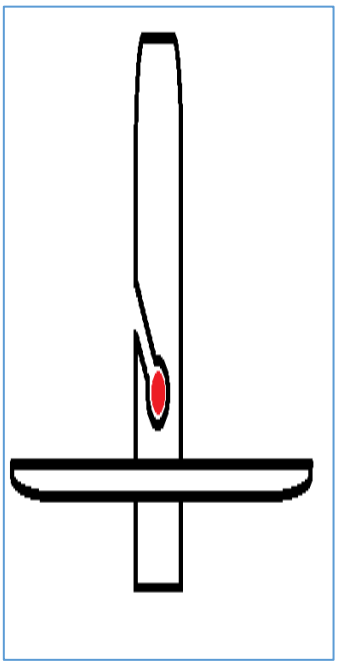


c. Open Sewing machine plates “**E”** & **“F”**

2. Thread Break Detectors.

Tread the Need thread break detector and show on the picture below.

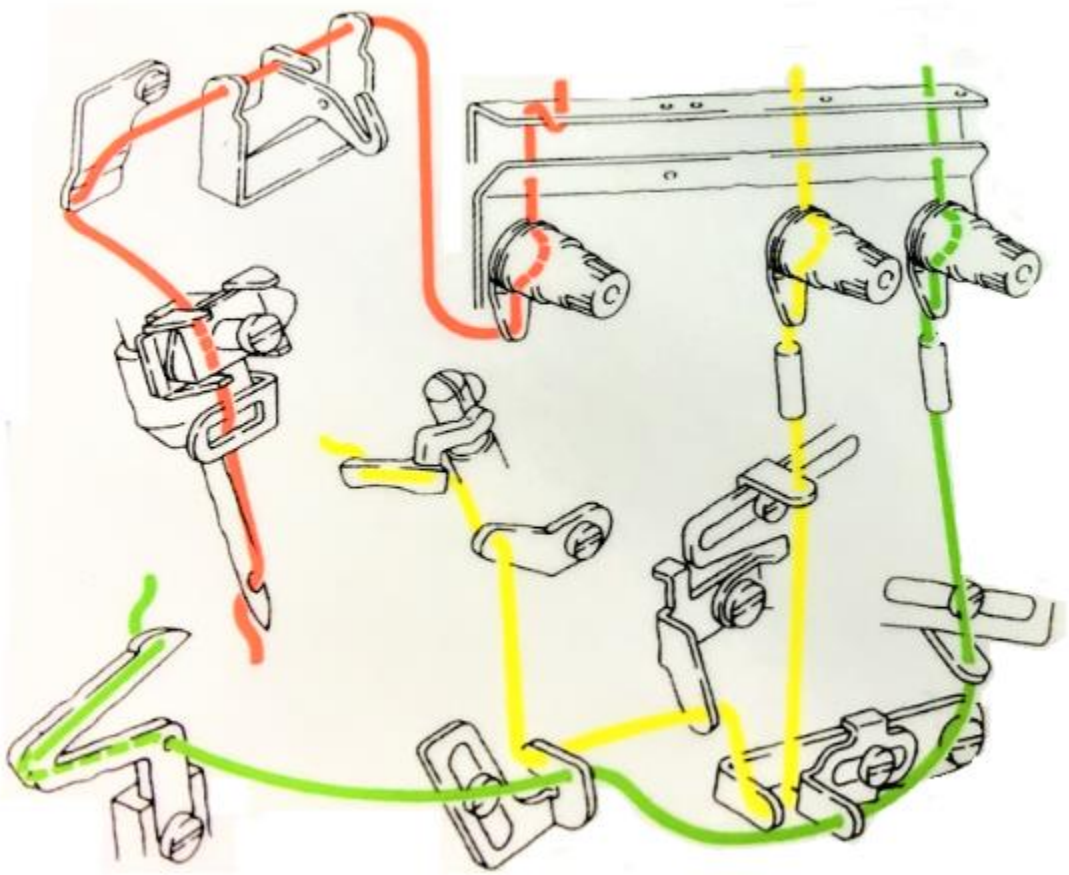




3. Threading the Sewing Head.

Refer to the sewing machine manufacturer for the correct threading

Pegasus EX5200 Series



4. Pre-Sewing Test.

a. Press Foot lift pedal to raise the foot.

b. Add a piece of material under the presser foot and release pedal

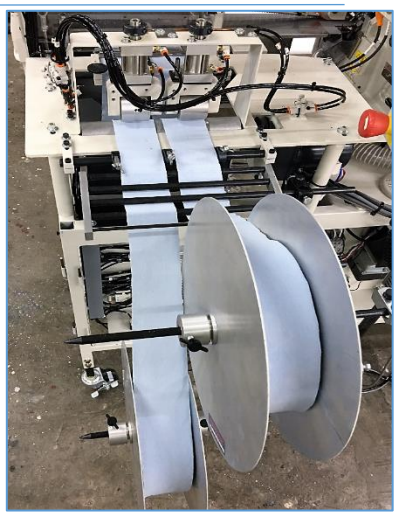
c. Press Sewing pedal and sew a piece of material.

d. Keep sewing and testing the seam

e. Run chain out of the material.

f. Press CUT BAND (Automatic Mode) button on the main control box to cut the thread chain. Reposition all covers.

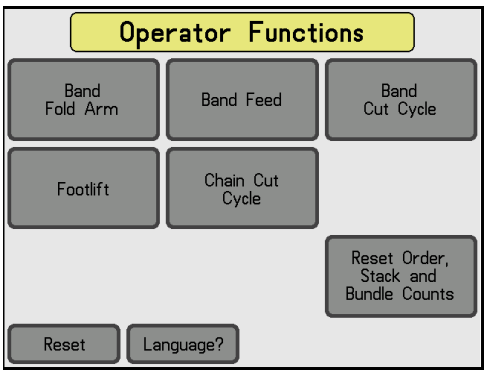
5. Load Rolled or Festooned Rib Knit



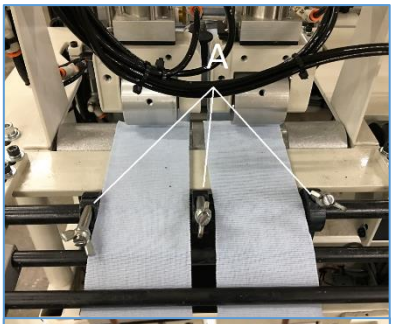
Load the rolls of fabric on the roll holder and align the roll with the guides.

For single rolls use the right roll holder and the right take-up roller

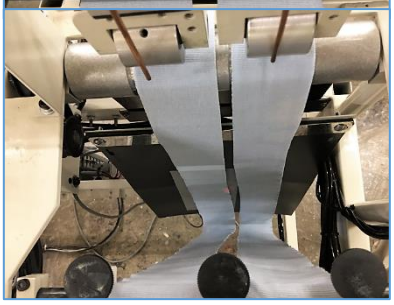
Use Operator Function Screen as needed, and then push Reset to return to Start Page



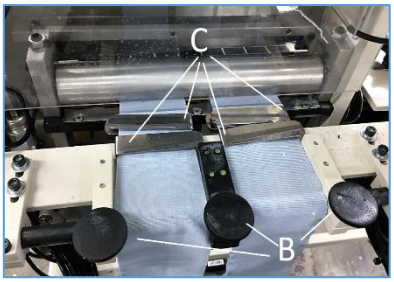
Lay the end of the fabric over the slack feed roller. Place your hand on the roller and rotate the roller to feed the fabric between the rollers, or press "FEED BAND" on the control box. Use the three collars **“A”** to guide the material and center it with the feeding rollers



Feed about 24" of fabric through the take-up rollers.



Feed the bands through the guides and up to the feed roller. Use the 3 Screws **“B”** to move the guides **“C”** to adjust the guides to a close fit to the band width.

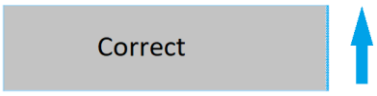


Sewing

After the operator loads rolled or festooned rib knit, programs the desired length, and starts the machine, the material is metered, cut, sewn, and stacked automatically. The stacker automatically indexes after the programmed number of pieces per bundle is sewn. The system automatically stops after the programmed number of bundles are completed or material supply is depleted.

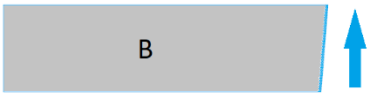
Inspect the first band as it is transferred after being cut, but before it is sewn. If the ends do not align properly adjust the flow control (1, 2) at the right of the fold and cut assembly according to the instructions printed there. It may also be necessary to adjust thumbwheel **#4** to get the ends to align properly.

Inspect the band after it has been sewn. If the end of the band is not sewn straight across, adjust the conveyor speed on the "Conveyor Speed" box by changing the thumbwheels.



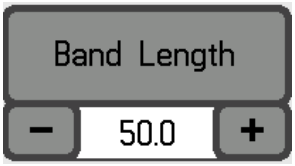
If the seam slopes to the rear of the band (A), decrease the speed the conveyor.

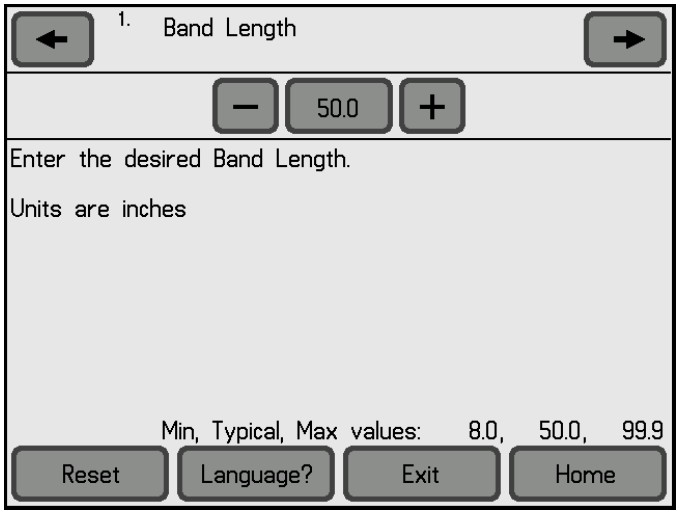
If the seam slopes to the front of the band (B), increase the speed of the conveyor driver box.



Adjust the band stop so that the band contacts the stop at the end of the transfer stroke. This helps keep the band straight in the conveyor.

Measure the band length and adjust length in Edit Order Menu under Band Length Button.





Maintenance

It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

General Safety Instructions

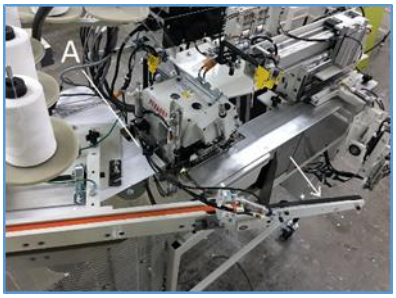
Maintenance should only be performed by trained, qualified personnel. Before performing any maintenance or repair work, switch off the electrical, pneumatic, etc. power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization. Refer to lockout/tag out procedures

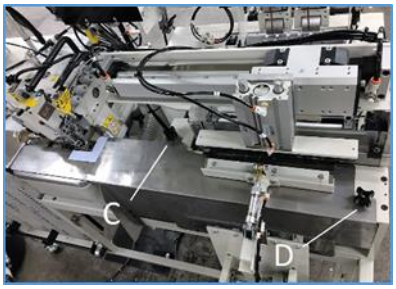
- Always wear proper safety equipment when operating or performing maintenance on any equipment.
- All recommended maintenance is for a single shift schedule; adjust as necessary for a multi-shift operation.
- Equipment should not be used for purposes other than designed or specified.
- The machine shall be switched off, come to a standstill, and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever.
- Use proper lockout/tag out procedures to secure the machine against inadvertent startup.
- Remove any oil, grease, dirt, and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work.
- Do not use any corrosive-cleaning agents.
- Use lint-free rags.
- Retighten all screw connections that have to be loosened for the maintenance and repair work.
- Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work

1. Preparation

Swing out feed belt and open all machine covers

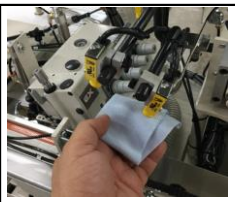
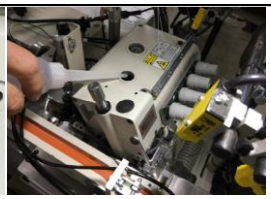
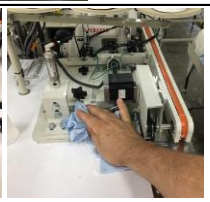
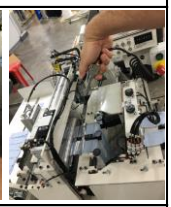
- Release nut “A” and Remove feeding belt from the sewing Area.
- Release Nut “C” & “D” and remove plate
- Open Sewing machine plates “E” & “F”





Preventive Maintenance 8 Hrs

Model:	1996B-ES	**Required Materials**
Serial #:		Oil can
Operation:	Auto Cuff, Collar, and Waistband	Oil for sewing machine
Sew Head:	Pegasus EX5200	Clean cloth
Serial #:		Compressed air
Needle:	B-27	

Before starting the day's shift with "The Machine Off"	
Wipe the lenses of all electric eyes and reflective tapes with a clean cloth.	  
Check for liquid waste in the air filter and drain if necessary.	
Check the oil level in the lubrication tank and add if required. Keep level between lines H and L of oil gauge.	 
After a day's shift with "The Machine Off"	
Check for thread accumulation on rollers, pulleys and the moving parts.	 
Open covers, blow out and wipe the machine with a clean cloth, and remove any dirt or tangled threads. Clean sewing motor ventilation.	  
Clean filter on waist container. Dump as necessary.	
Cover the machine and notify the supervisor of any unusual noises or abnormalities that were present during the working shift.	

3. SERVICE

NOTE: Maintenance should only be performed by trained, qualified personnel.

Lockout/Tagout Program

"Lockout/Tagout (LOTO)" refers to specific practices and procedures to safeguard employees from the unexpected energization or startup of machinery and equipment, or the release of hazardous energy during service or maintenance activities. This requires that a designated individual turns off and disconnects the machinery or equipment from its energy source(s) before performing service or maintenance and that the authorized employee(s) either lock or tag the energy-isolating device(s) to prevent the release of hazardous energy and take steps to verify that the energy has been isolated effectively. The following references provide information about the LOTO process.

Equipment Energy Control Procedure Lockout/Tagout Program				
Description:	**Band / Collar Maker**		Model:	**1996B-ES**
Manufacturer:	**Atlanta Attachment Co.**		Location:	
Energy		Location	Magnitude	Control Method
Electrical:	X	Disconnect/Ctrl Box	**220V**	Lockout & Tag
Pneumatic:	X	Main Regulator	**80 PSI**	Lockout & Tag
Gravity:	X	Belts		
Remember to Release All Stored Energy!				
Shutdown Procedure:				
Inform all affected personnel that the machine will be in Lockout status. Turn the power and pneumatic disconnects to the OFF position. Fill out the tag with necessary information of the Lockout. Install the Lockout device. Verify all stored electrical energy has been released by pressing the power on button. Also, use meter to test circuits in the electrical panel to insure stored energy is released there as well. Perform necessary maintenance, services and/or repairs.				
Startup Procedure:				
Inform all affected personnel that the Lockout of this machine is being removed. Replace any guards or safety devices which may have been removed during maintenance. Remove the Lockout device and tag. Turn the power and pneumatic disconnects to the ON position. Push the green button on the back of the control panel to turn the machine on. Inform all affected personnel that the Lockout has been removed and that the machine is ready for normal production operation.				

Approved By: _____ Date: _____

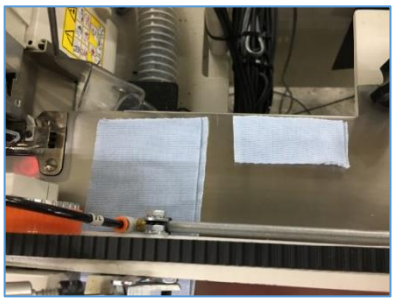
Mechanical

NOTE: All maintenance should be performed by a qualified service technician.

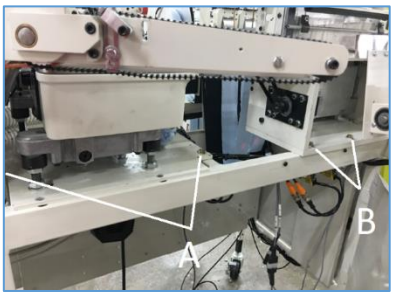
1. General Alignment.

Trimmed off material on the sewing head should be approximately ¼ inches wide. Readjust Sewing head Assembly (4 Screws A) or the Guillotine assembly (3 Screws B) to reach the desire amount.

Right amount of Cut



Too much Material



Adjustment Screws

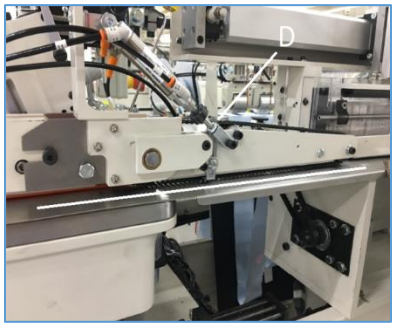
2. Conveyor

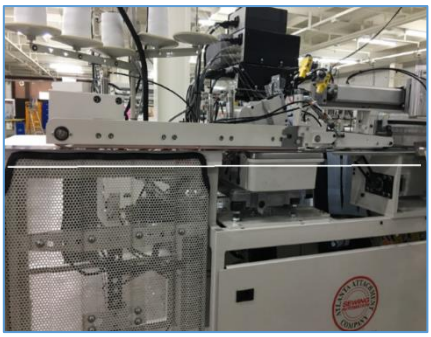
a. Alignment

The conveyor needs to be aligned with the machine frame.
Adjustment is made by loosening both screws **"B**" and repositioning the whole assembly.
Make sure that locking screw "A" is tight holding the assembly on the maximal inside position. Assembly should be as close as possible to the sewing head without touching it or interfering with the electric eyes operation.

b. High

Release all the tension on the springs (Screws **"C**") and let the whole assembly rest on the table.
Lower the front conveyor and align it with the back conveyor loosening the nut D and rotating the cylinder shaft.
With the front conveyor lowered, align the whole assembly with the table. Make sure the belts contact the plates along the entire length of the conveyor. If necessary, level the sewing head to the front and rear plates.





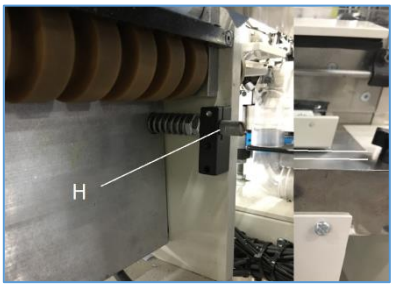
c. Pressure.

Release all the tension on the springs (Screws **"C"**) and let the whole assembly rest on the table
Tighten both tensioning screws until contacting the springs and do a couple of extra turns to keep a minimal pressure on the belt assembly.

Place a piece of material under the conveyor and manually run the conveyor to check that the material is transported all way from the front to the back of the machine.

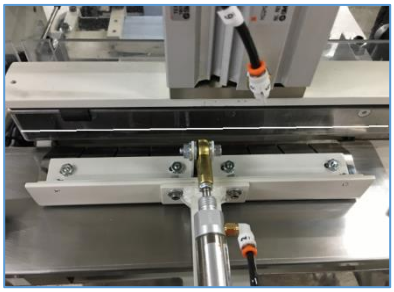
3. Guillotine

For proper operation, the material must cut cleanly. For pressure adjustment, adjust the pressure screw **"H"** The correct pressure is the minimum necessary to get a clean consistent cut. If there are individual uncut strands, check the blades for knicks on the cutting edge.

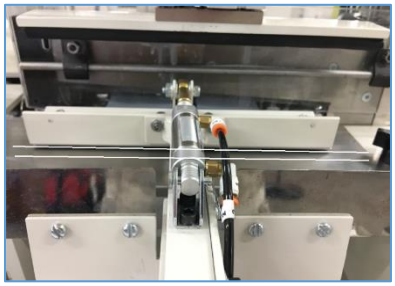


4. Band Fold Clamp

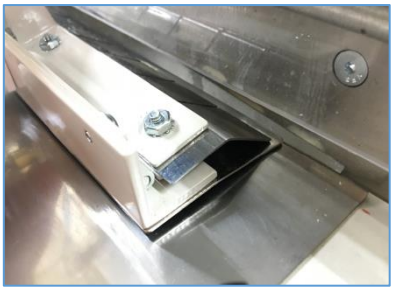
In the home position, the fold clamp should be as close as possible to the guillotine with out to touching, parallel and leveled to the table.



Parallel

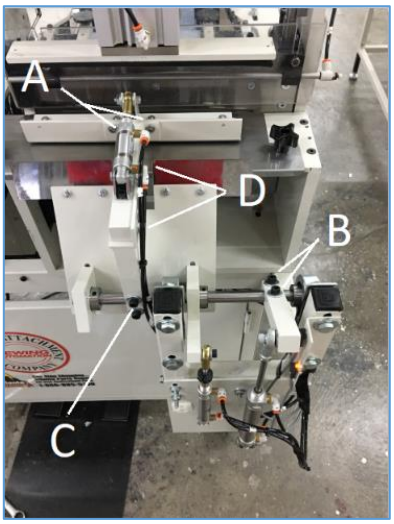


Aligned in high



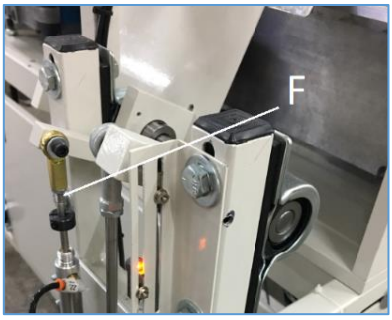
Distance from Knife

Adjust with screws **"A" , "B**", **"C"** and **"D"** if required.



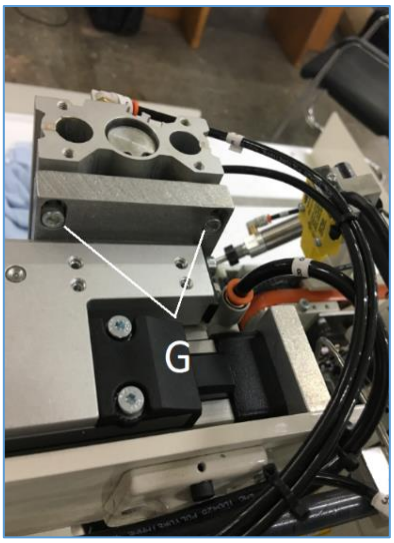
5. Band Clamp

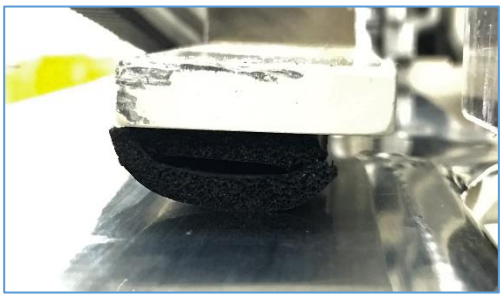
In the clamping position, the band clamp should touch the cover plate and hold the material in position after the fold clamp releases it. Adjust pressure by moving the cylinder shaft.



6. Transfer Clamp

The transfer clamp transfers the material from the guillotine to the front belt without changing the cut materials' position. In the extended position, the clamp has to hold the material but not fully compress the rubber. Adjust the cylinder height using the screws "G" if required.

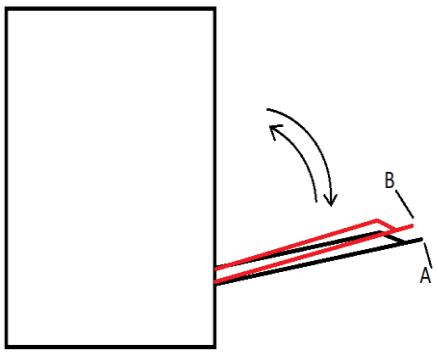




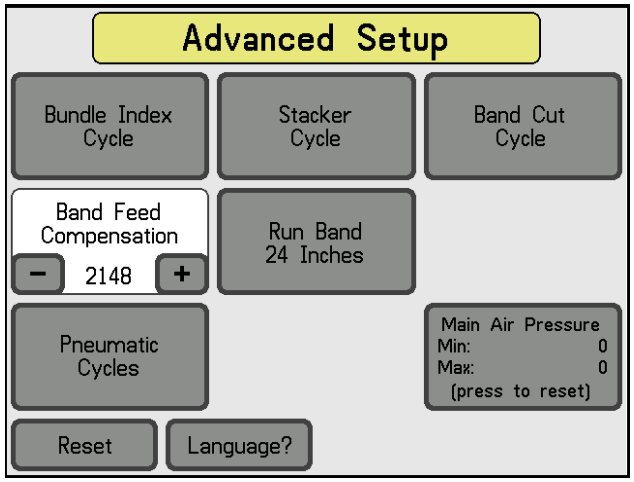
7. Stacker

Stacker speed is defined by 2 flow control connected direct to the air cylinder. Cycle time in Advanced Setup Screen The movement must be fast enough to remove the part from the conveyor

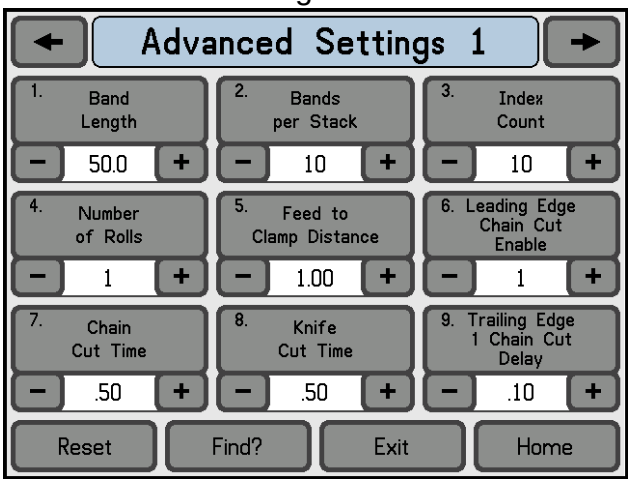
(Use air flow control), but the arm should not reach the maximal expanded position "A"



Manual Operation Screen

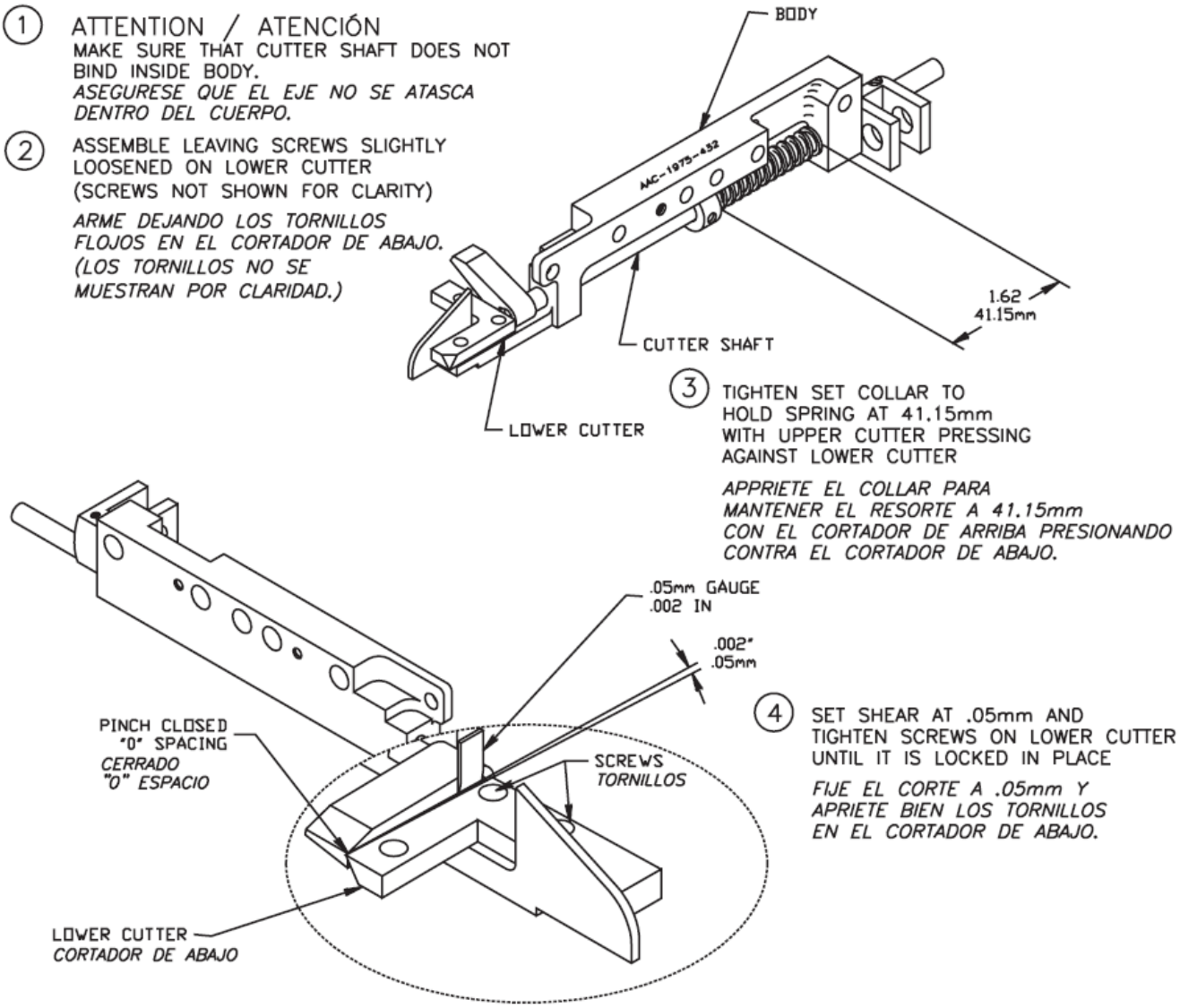


Counter Settings Screen



Touch a Button for Help or more details or explanation of what a button controls

8. Chain Cutter



CUTTER ADJUSTMENT INSTRUCTIONS

Pneumatic

NOTE: All maintenance should be performed by a qualified service technician.

1. Air Maintenance Unit FR

The FR (Filter Regulator).unit assembly is located behind the table. It has 2 components, the Pressure Regulator, and the Air Filter. This unit does not require an air lubricator.

a. Pressure Regulator

The purpose of the regulator is to keep the operating pressure of the system (secondary pressure) virtually constant regardless of fluctuations in the line pressure (primary pressure) and the air consumption. The presser regulator is set to 80 psi.

b. Air Filters

Clean air from your compressed air system is essential for the safe and efficient operation of this equipment. This unit has 2 compressed air filters. They remove contamination from compressed air after compression has taken place. Harmful contaminants like oil, dust, dirt, rust, and water-alone or in combination-can attack your system and clog sensitive pneumatic parts.
Condensate is drained manually by pushing the red bottom on the drain plug. They require a regular maintenance schedule (i.e., once per shift).

2. Venturi Chain & Trim Waste

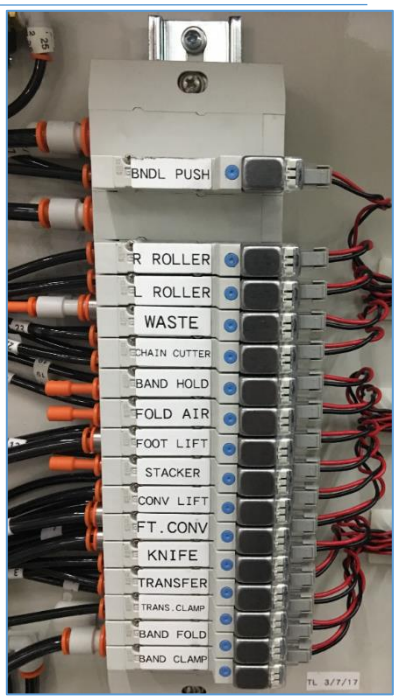
The purpose of the waste venturi is to pull the thread and, material trimmings away as they're cut off. The air flow should be enough to get the material from the head to the waste can.

- If it is set too high, it will pull the edge of the garment into the knife and cut a hole in it.
- The operator needs to make sure that the trimmings aren't very long because that can also pull the garment into the knife.

3. Flow control panel

The panel is located inside the end door under the guillotine assembly.
Each number on the left match the number of the airline connection at the cylinders.

4. Solenoid Valve Stack Manifold



It is located inside the control box
The control system voltage is 24 VDC.
Each valve can be activated manually by pushing the blue button.
The red light means the valve is energized.

5. Air Pressure Switch.

There are two located inside the control box.

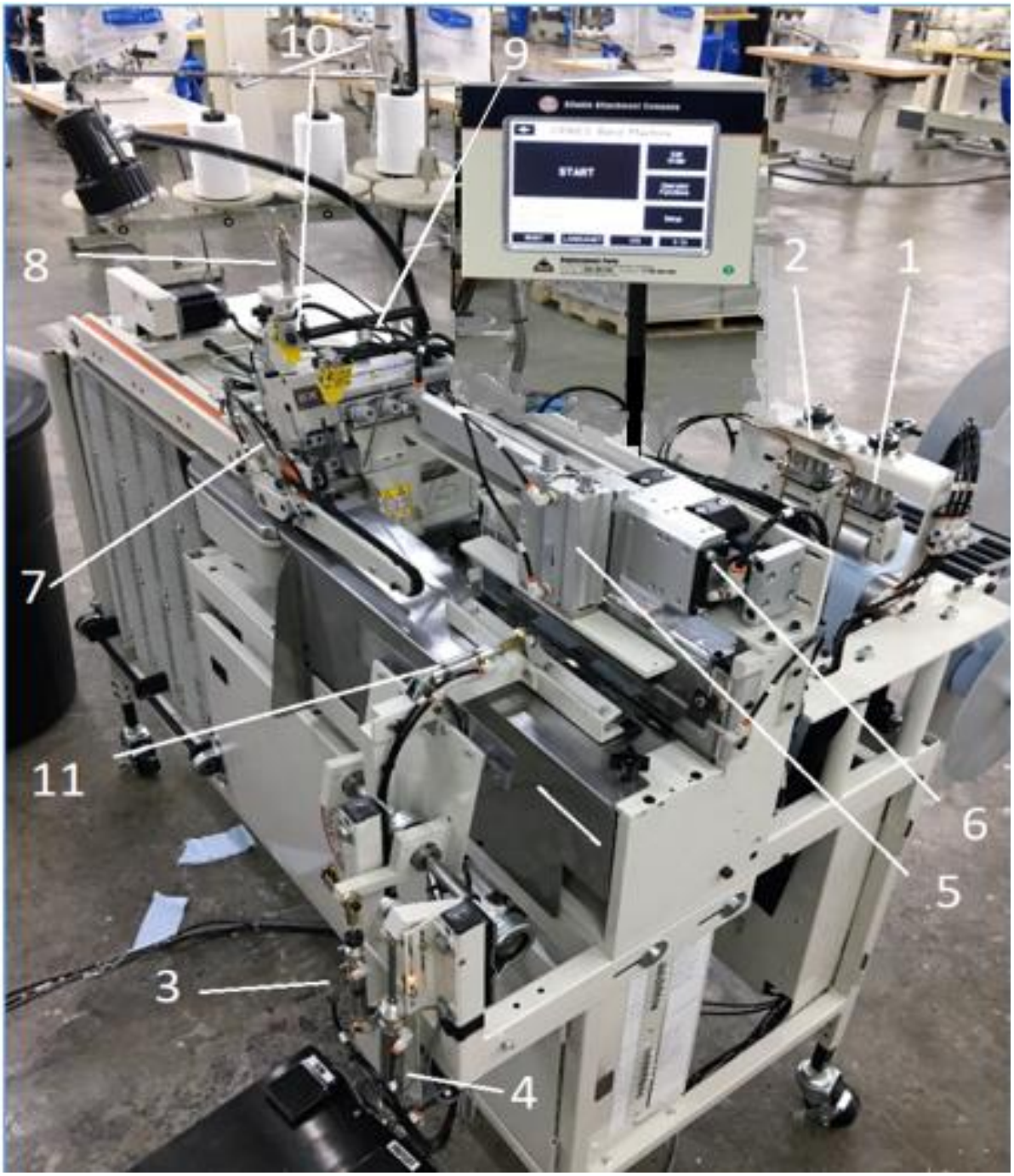
a. SW#1 Piece Counter

The first pressure switch is the signal to the piece counter. Every time the Rear Conveyor Lift Cylinder is activated it sends a signal from the switch to the counter. For more details of connections see plumbing diagram located at the ends of the Spare Parts Book. Part # AAVF51FM1B

b. SW#2 Bundle Counter

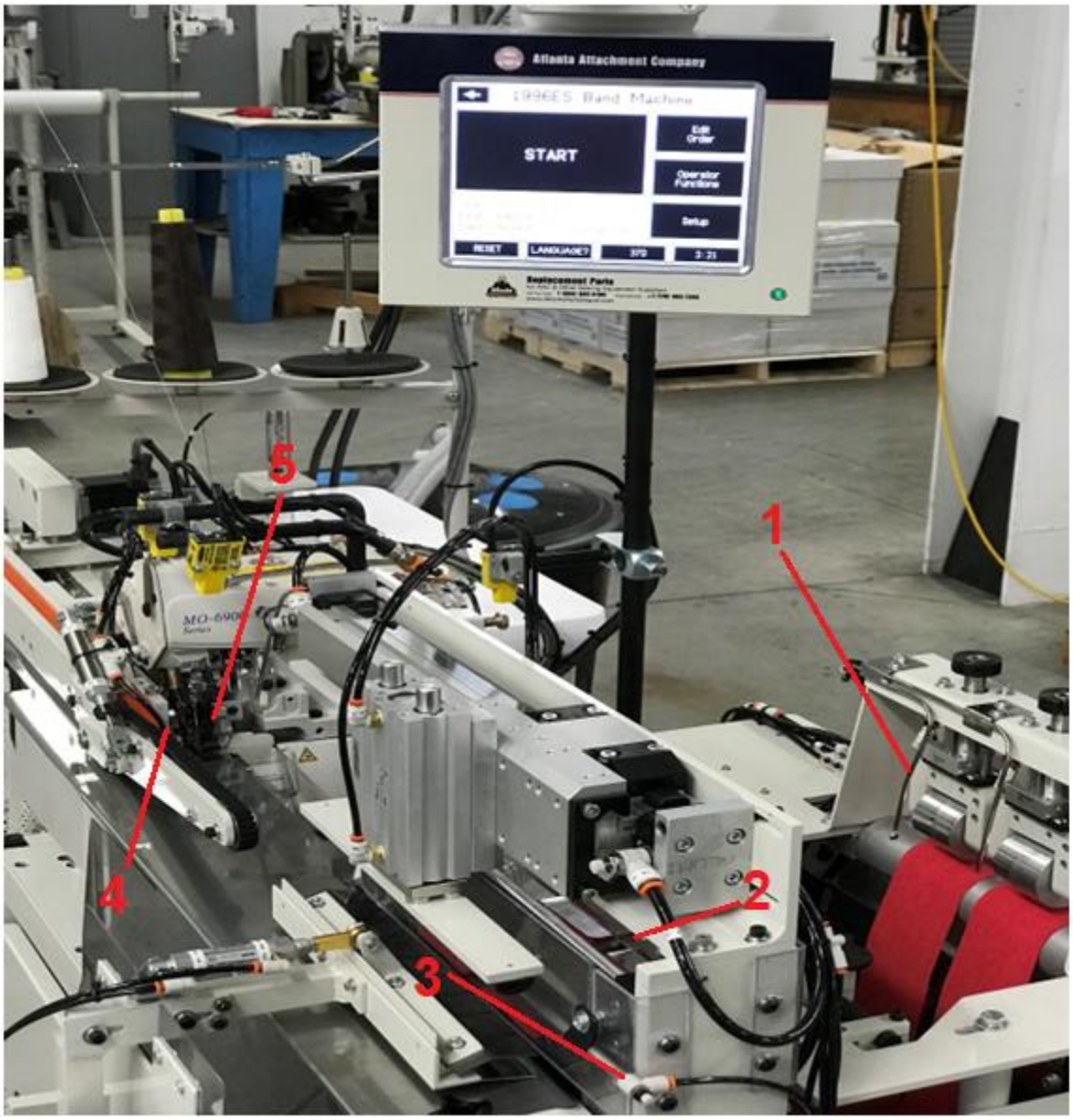
The second pressure switch is the signal to the Bundle counter. Every time the Bundle Indexer Cylinder is activated it sends a signal from the switch to the bundle counter.

6. Air Cylinders



1.- Left Roller Lift	5.- Transfer Clamp (5/6)	9.- Foot Lift (17)
2.- Right Roller Lift	6.- Transfer Cylinder (7/8)	10.- Chain Cutter (23/24)
3.- Band Hold (21/22)	7.- Front Conveyor (11/12)	11.- Band Clamp (1/2)
4.- Band Fold (3/4)	8.- Rear Conveyor Lift (13)	

7. Blowers



a. Puller Blowers Tubes

Help to form the loop of the feeding material.

b. Air Jet at Folder

Help to load the material into the clamp. It is located under the feed roller material guide plate in front of the guillotine.

c. Uncurled feed air

Outer uncurl jets make the edge of the material lay out. Helps to feed the material when it is pulled by the feed clamp.

d. Front Conveyor Air

Helps to uncurl the top ply of the material before sewing.

e. Air in front of the foot

Helps to guide the edge cut material into the waist system.

Electrical

NOTE: All maintenance should be performed by a qualified service technician.

1. Ground

This unit needs to be connected to ground (earth) for several reasons. In mains powered equipment, exposed metal parts are connected to ground to prevent user contact with dangerous voltage when electrical insulation fails. In electrical power distribution systems, a protective ground conductor is an essential part of the safety Earthling system. Connection to ground also limits the build-up of static electricity

2. Main Power Contactor.

When you press the green button, it activates the contactor to turn on the power to the machine.
It also functions to protect the unit after a power failure. It will keep the machine without power until the green START button is pressed.

3. Stepping Motor Drive Box (Middle)

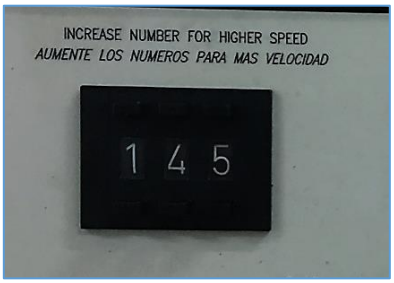
This box controls the speed of the conveyor for sewing and jogging to stack. It also drives the band feed stepping motor. The thumbwheels should be set to match the sewing speed of the seamer. If the seamer stitch length is changed, the conveyor speed must be adjusted also.
Different fabrics will vary slightly in the speed they feed through the seamer. The operator may need to make small changes in the conveyor speed to keep the seamer sewing the end of the band square Presser foot pressure effects the feed speed also. Adjust pressure foot pressure to the medium to light range. Part Number: AP-28-800P
The thumbwheel switches on the front of the control box set the speed of the conveyor stepping motor. During the loading cycle, the feed belt is driven by the jog signal. The speed is set using a potentiometer on the inside of the box.

a. JOG button

This button is disabled. Use "Conv. Jog" button on the main control box to operate the conveyor motor.

b. Thumbwheels

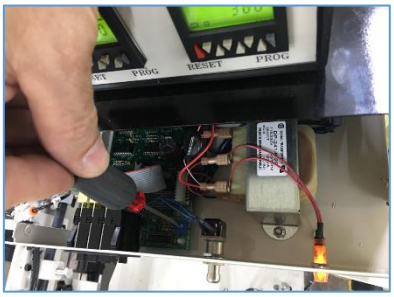
They are used to set the conveyor sewing speed to the speed of the sewing head. This number is determined by the seamer stitch length and the fabric feeding characteristics. This value may need to be adjusted depending on stitch length, fabric, feed dog height, and presser foot pressure.



- If you change the sewing stitch length, it will be necessary to adjust these numbers to re-synchronize the conveyor with the sewing head.
- Decreasing the number makes the belt go slower. For example, if you changed the stitch length from 10 SPI to 11 SPI, you would need to decrease the number in the thumbwheels by 10% to match the 10% shorter stitch length.

c. Potentiometer

Inside the box there is one small potentiometer. It sets the pre-feed JOG speed of the Belt feed



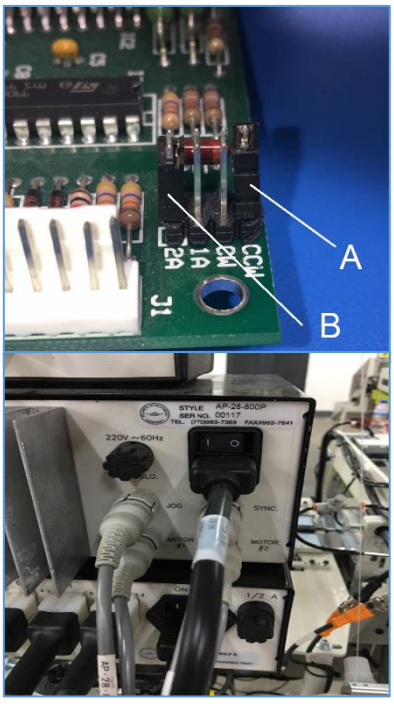
d. Jumpers

The direction of rotation of the feed roller and conveyor is controlled by the CW/CCW jumpers on the driver boards inside the box and should be set CCW. There are jumper clips for setting the motor currents on each driver board. The feed roller drivers are set to 2A.

- The top driver board powers the belt feed and
- The bottom driver board powers the band pre-feed.

e. Power

The back of the box has an On/Off switch, fuse, JOG cable, 3 stepping motor cable and Sync cables. Leave the On/Off switch ON all the time.

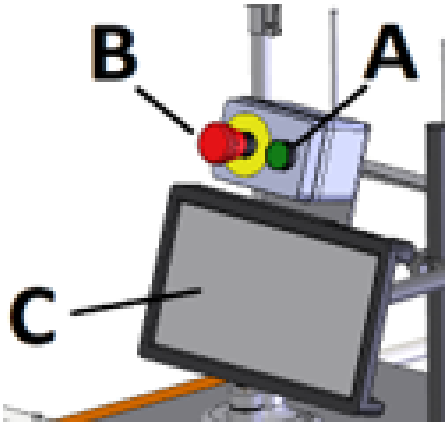


NOTE: When working on the box always disconnect the power cord before servicing.

Individual Components

1. Control Panel

The Control Panel allows the operator to start and stop the automatic function of the machine, shut off power to the machine in the event of an emergency.



Emergency Stop (B)

Pressing this button will turn off power to the machine. This button will lock when pressed. Twisting the button will cause it to unlock and return to its normal position.

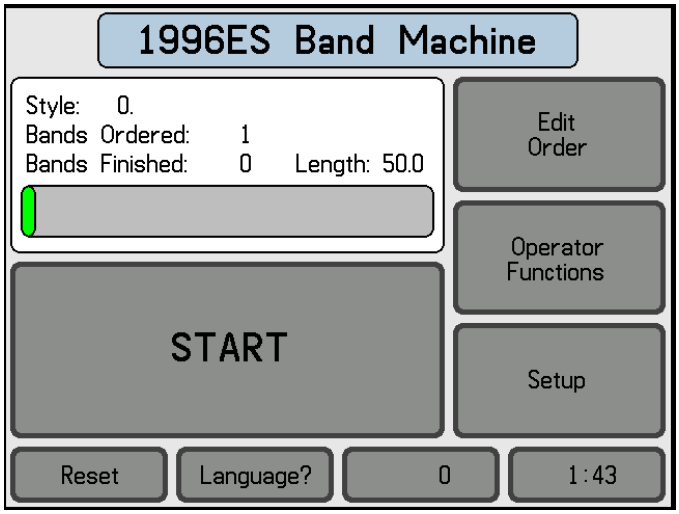
WARNING!! Unlocking the button with the Power On engaged will turn on power to the machine.

Power on (A)

Power the machine “ON”.

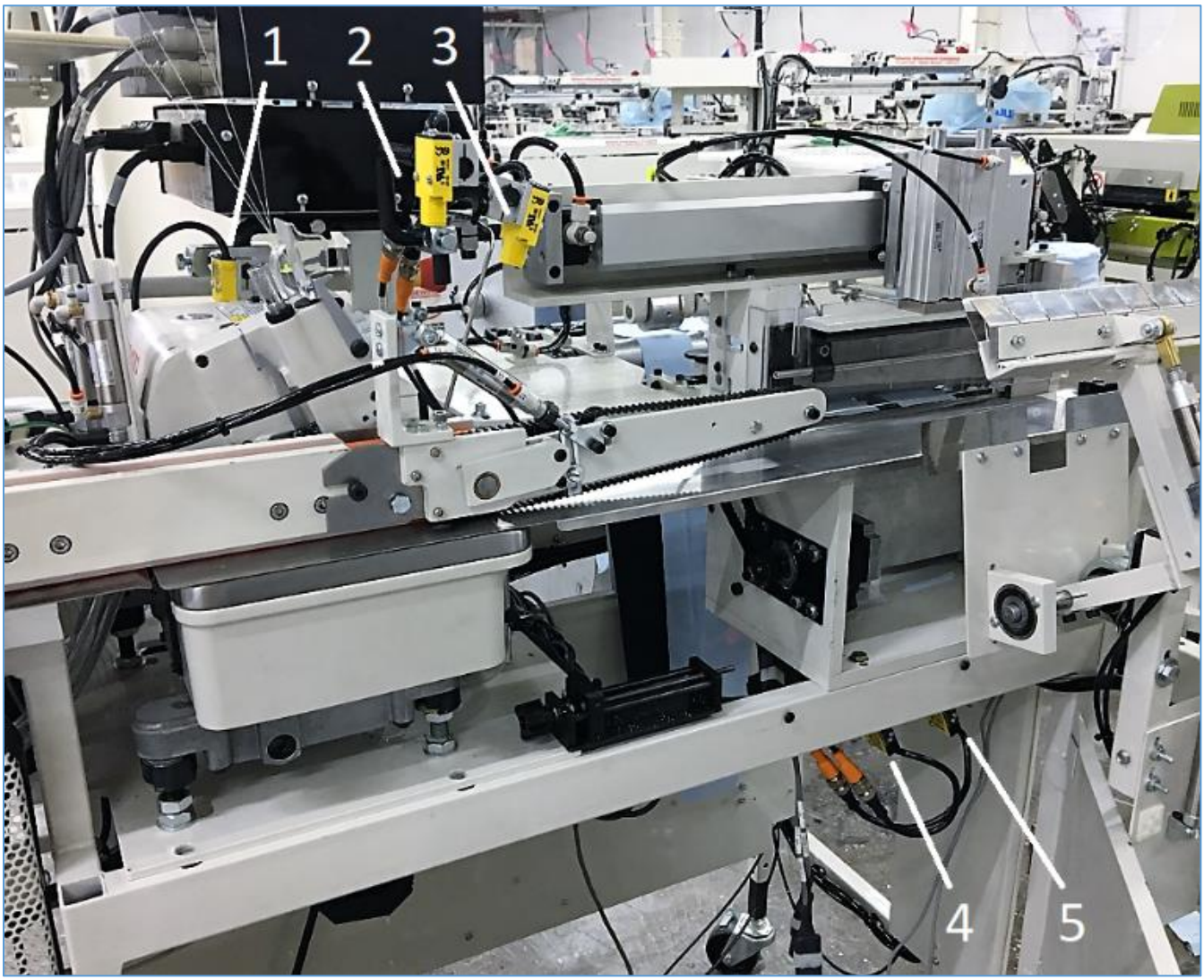
Serial Bus Control (C)

Control all machine functions. See more details available on related chapters in this manual



2. Electric Eyes

The unit has 5 electric eyes as follows.



a. Eye #1 Needle Positioning

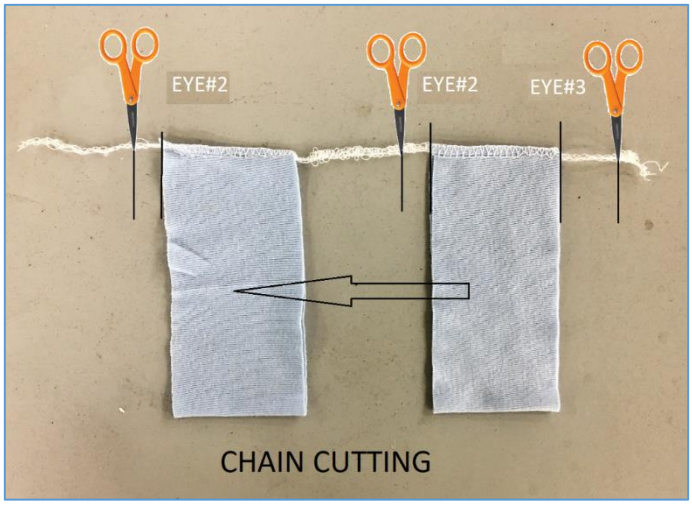
The function of eye number one is to position the needle.
The setting of eye number one is to stop the needles as they move upward, and the feed dog teeth are level with the throat plate.

b. Eye #2: Leading Edge

The function of eye number 2 is to control the length of the leading-edge chain on each piece. The position of eye number 2 on the reflective tape controls the length of the chain.

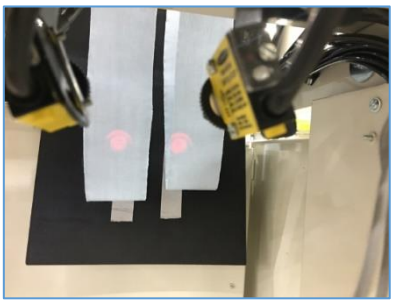
c. Eye #3: Trailing Edge Cut

The function of eye number three is to read the trailing edge of the second piece to start the trailing edge chain cut count.
The length of the chain is controlled by thumbwheel number 5.



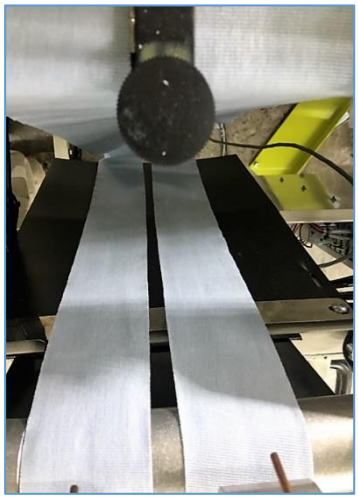
d. Eye #4: Lane 1 Roll Material

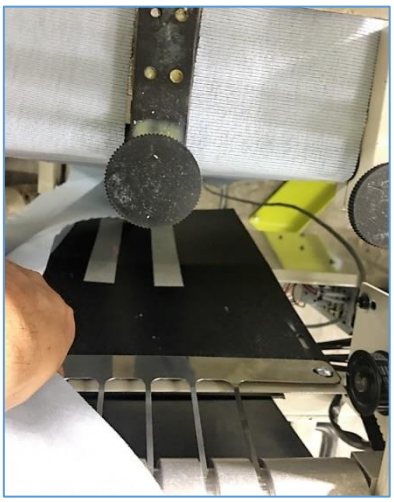
The function of eye number four is to control the feeding of material in lane 1.
The eye should be positioned so that the slack loop in lane 1 is the desired length.



e. Eye #5: Lane 2 Roll Material

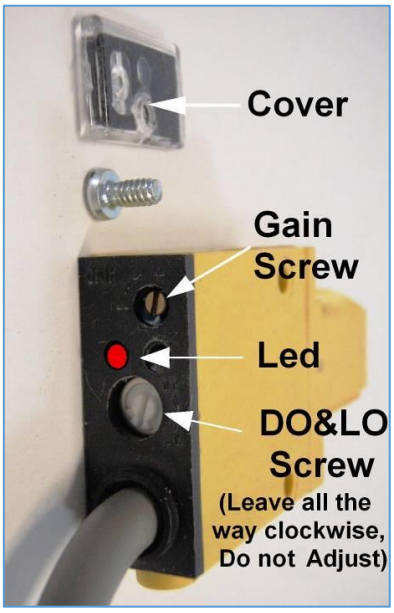
The function of eye number five is to control the feeding of material in lane 2.
The eye should be positioned so that the slack loop in lane 2 is the desired length.





f. Eye Sensor Adjustment

Remove the clear plastic cover from the end of the sensor. There are two adjusting screws under the cover. One is labeled “GAIN” and is used to set the sensitivity of the sensor. The other screw is labeled “DO & LO” and should always be fully clockwise.
With the end of the sensor pointing at the center of the reflective tape, turn the “GAIN” screw counterclockwise until the red LED indicator is off
Then turn the “GAIN” screw clockwise until the LED indicator comes on.
Then turn the “GAIN” screw one full turn clockwise. The LED indicator should be blinking slowly approximately 2 pulses per second. The eye on the hand wheel should be at least 1 1/2 full turns.
Cover the eye so that the sensor cannot see the reflective tape and the LED should go off.
Part #FFSM312VQ



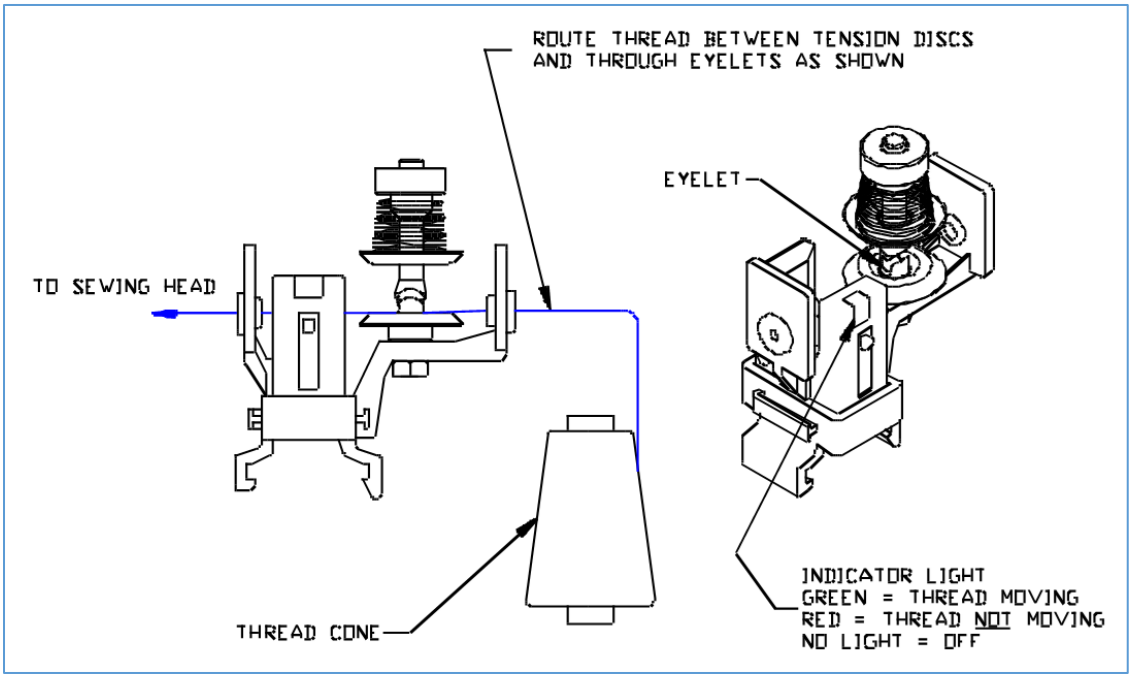
g. Reflective Tape Maintenance

Use a soft cloth for cleaning. Do not use chemicals or abrasives to clean it. Avoid any contact with oils and liquids. Do not touch the tape with bare fingers. If tape is dirty or opaque, the eye may not function correctly.

3. Thread Break Detectors.

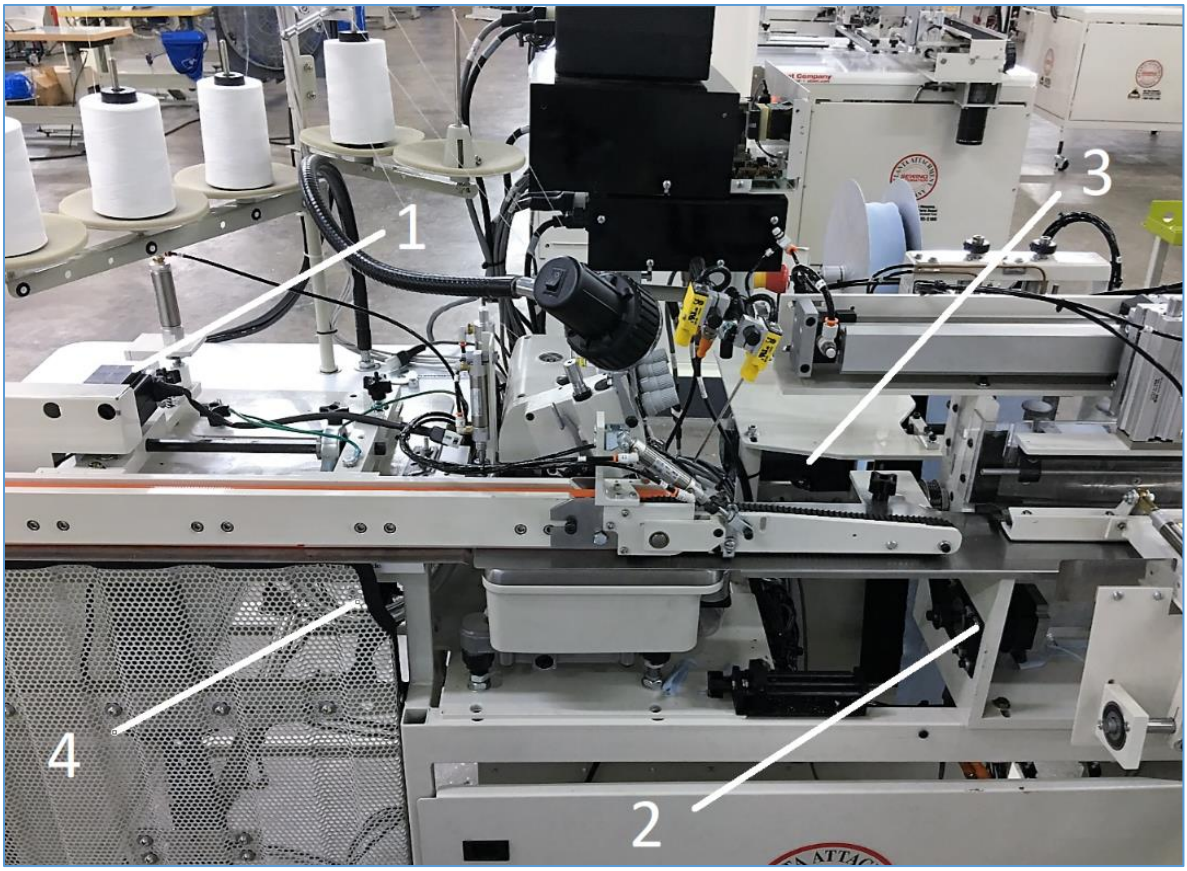
a. Needle Thread Sensor

Part Number: (4003-3WT2). Position finger on top of indicator light to activate or deactivate



4. Motors

There are 4 motors in the machine. Conveyor Stepping Motor, Band Feed Stepping motor, Loop motor and Sewing Machine Motor.



a. Conveyor Stepping Motor. (1)

It is controlled by the stepping motor drive box. The belt speed during sewing is controlled by the thumbwheel switches. The jog speed is controlled by an internal potentiometer. (See Stepping Motor Drive Box for more details).

b. Band Feed Stepping Motor (2)

It is powered by the stepping motor drive box. It runs at a preset speed that cannot be changed. The Main control box controls the steps that this motor will do according to the material length set on the first 3 thumbwheel switches.

c. Loop Motor (3)

The motor is activated by the eyes 3 and 4 (See electric eyes for more details). If either of these eyes is uncovered, the motor will start running. The left or right roller lift cylinders will be activated according to the eye that was uncovered, feeding the material until the eye is covered again.
The speed of the motor is controlled on the Speed Control Unit on the electric cabinet. Increase or decrease the speed according to amount of material that needs to be fed.

d. Efka Sewing Motor

It is located under the table. It is the one that runs the sewing head. The control box always needs to be with the switch in ON position.

1. Programming the Code Number

NOTE: The parameter numbers in the illustrations below serve as examples and may not be available in all program versions. In this case, the display shows the next higher parameter number. See List of Parameters. If you have a screen with 4 digits your access code will be 3112 instead of 311

2. Parameter Settings EFKA DC1500

PARAMETER	RANGE	VALUE	DESCRIPTION
Do this first	*****	****	Perform a master reset before programming, see below
290		5	Mode of operation. MUST SET THIS PARAMETER FIRST!
026		0	Treadle mode
111	200-9900 rpm	4000	Maximum speed as requires
153	0-50	35	Braking power at standstill.
161	0-1	1	Motor rotation. 1=CCW
204	001-100	1000	Footlift (FL) holding power.
270	0-5	1	External handwheel sensor configuration.
272	0200-2550	800	Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111.
362	0-1	1	Position sensor voltage: 0 = 5V, 1 = 15V
436		0	Use code "5913". This disables an input that was causing box to reset itself.
401		0-1	change from 0-1 to save parameters

Front panel LED's:		
LED 1:	Off	
LED 2:	Off	
LED 3:	Off	
LED 4:	Off	
LED 5:	Off	
LED 6:	Off	
LED 7:	?, Stop at needle down.	
LED 8:	?, Stop needle Up	

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "5913"
3. Press "E" once and "2.0.0." is displayed. This is a parameter.
4. Press "E" again and the value for parameter 200 is displayed.
5. With the value on the screen, adjust to desired setting.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. **Run sewing head to save parameters before powering down**

To Perform Master Reset of Parameters:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "5913"
3. Press "E" twice and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Press "P" to exit programming mode with all default values.

e. Panasonic Motor

Programming D9 Motor

1. Turn off power to machine.
2. Hold Up Arrow button, Turn on the power
3. Display shows Axxx
4. Use + & - buttons to scroll to desired parameter #.
5. Press > to toggle to parameter value.
6. Displays shows the parameter value xxxx.
7. Use + & - buttons to change parameter value.
8. Press enter (E) button to save change.
9. Press > to toggle to back to parameter number.
10. Use + & - buttons to scroll to next desired parameter #.
11. Repeat until all desired parameters are updated. Be sure to press enter (E) after changing the parameter values.
12. Turn off the power momentarily.
13. For 1996, set the following parameters:

    A 27 = 1 (Stop needle up)
    A 29 = 1 (Rotation, 1 CCW, 0 CW)
    A 70 = 5000 (max speed)
    A 91 = 1 (Pneumatic solenoid foot lift, 100% modulation)

1. Turn off power to machine.
2. Hold “E” & “-“ buttons, Turn on the power
3. Use + & - buttons to change parameter value to F166.
4. Press > to toggle to parameter value.
5. Use + & - buttons to change parameter value to 600 (one minute foot time-out).
6. Press enter (E) button to save change.
7. Turn off the power momentarily.

Serial Bus

The Serial Bus System, based on only four wires, is self-diagnostic and offers helpful solutions to solve the problem. An operator using a touch screen control panel manages this rugged, uncomplicated system. Designed to international standards, this multi-lingual, easy to operate interface will allow parameters to be saved, allow technician access with password protection, and offers a built-in production performance monitor which can be networked to a central computer.

A warranty of 3-Year covers all electrical components of the state-of-the-art Serial Bus Control.

1. Touch Screen

Caution: Do Not Use Any Sharp Objects To Touch The Screen

Installation

To install new screen requires no special procedures and it is plug and play.

NOTE After replacement Machine assemblies will reset or move to home positions. Screen will return to the Main Display and is ready to run.

2. Modules

a. Gateway Module…4080-900

Interface module, connects the touch screen to the serial bus control system

b. Input Module …4080-200

Detects air pressure provided to machine and sends a low-pressure signal, if it occurs to the controller

c. Output Module…4080-140

They are responsible for transferring signals from the computer to the working elements such as valves, motors, and relays, etc.

d. Output Module …4080-130

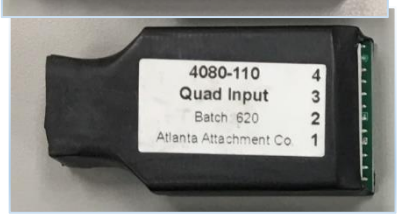
They are responsible for transferring signals from the computer to external connections, servo motor controls (electrically insolated)

e. Input Module…4080-120

They are responsible for transferring signals from the machine to the computer such as external relays. (Electrically insolated)

f. Input Module…4080-110

They are responsible for transferring signals from the machine to the computer such as switches, electric eyes, sensors, etc.



NOTE: Even though all output and/or input modules within the machine are identical, they cannot be moved to another location on the serial bus cable, as the computer automatically assigns a working address for each one.

- If a replacement is necessary, always replace with a new or loaner module from another machine.
- Electrical Power to the machine must be turned "OFF" during replacements.
- Computer will show an error if one or more modules are missing.
- Removing more than 1 module at a time will require reinstalling all of the modules

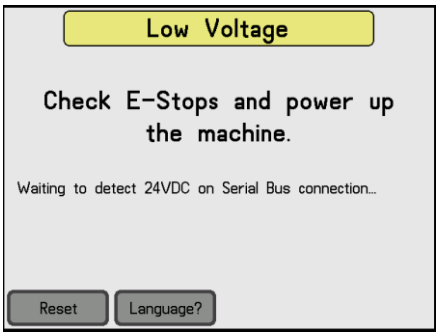
Procedure:

Electrical Power to the machine must be turned "OFF" during replacements

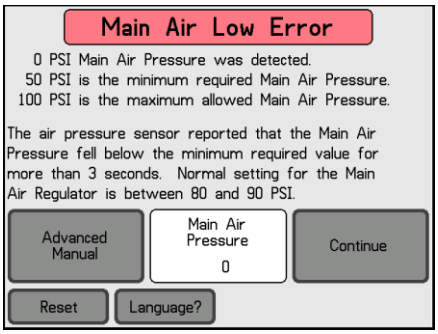
Remove the old module and connect the new one, after turning on the power, the computer will reassign the address to this new module.

Computer will show help screens or errors when present, such as low voltage and if one or more modules are missing.

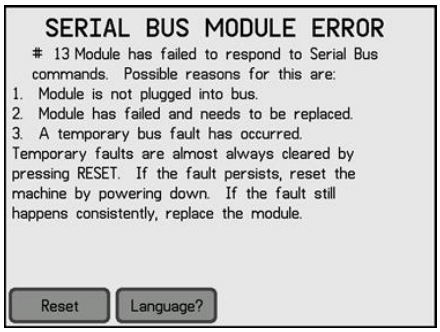
Low Voltage Error



Low Air Pressure



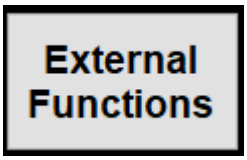
Missing Module Error



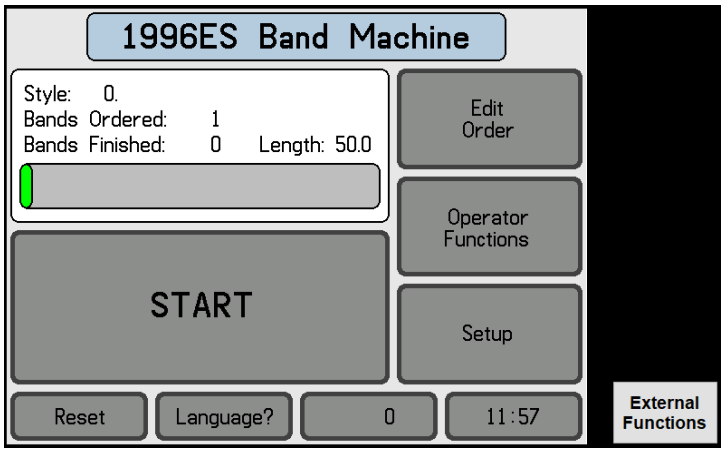
3. Program Update

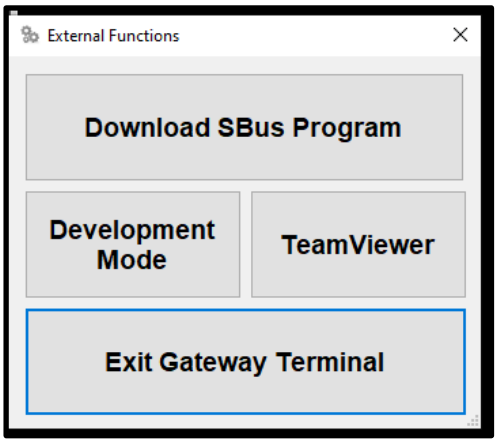
NOTE: Important, before starting the procedure below, go to Advanced Settings and write down all the settings shown in these screens.

a. New Program will be loaded from the Gateway PC Desktop.
b. Gateway PC on the Workstation can access internet Wi-Fi.
c. Click-on External Functions button (located on the lower right side of the screen) and Open TeamViewer on the PC.
d. Remotely connect to the Gateway PC with your PC and transfer the program file to the Desktop.
e. Using the External Functions, click on Download SBus Program and select the new program file from Desktop location.
f. Wait for the Download to complete.
g. Gateway Terminal will restart, and begin running the new program, after recognizing and applying the new software update.

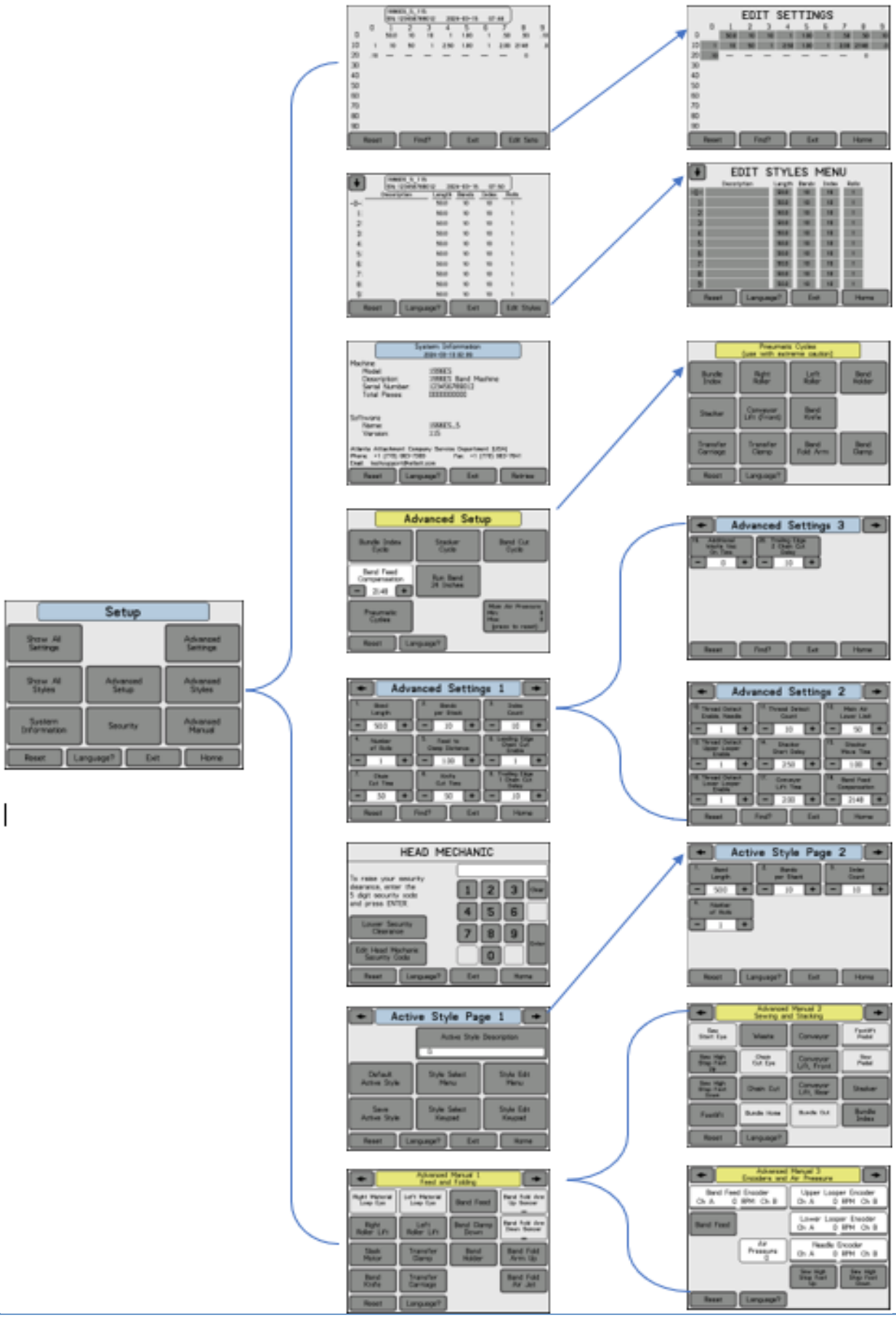


Now that the process is complete, go to Advanced Settings and verify them using the settings you wrote down at the beginning of the process. Make any necessary corrections.



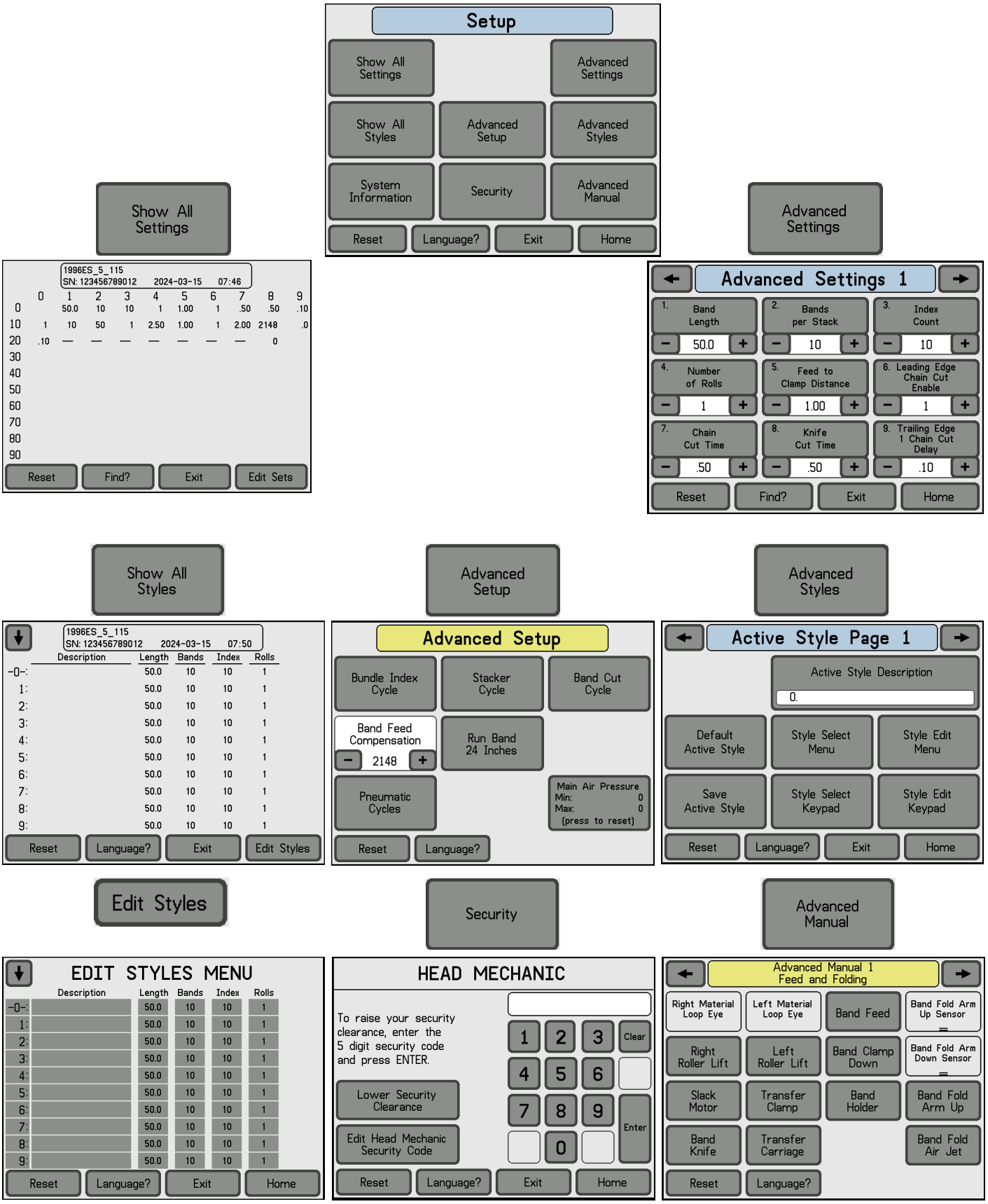


4. Technical Screens

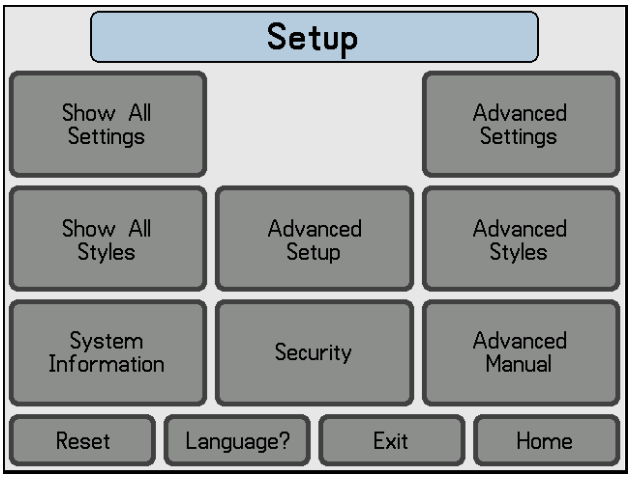


1. SET UP

Show ALL SETTINGS, ADVANCED SETTINGS **Error! Bookmark not defined.**and MACHINE DIAGNOSTIC



a. SETUP

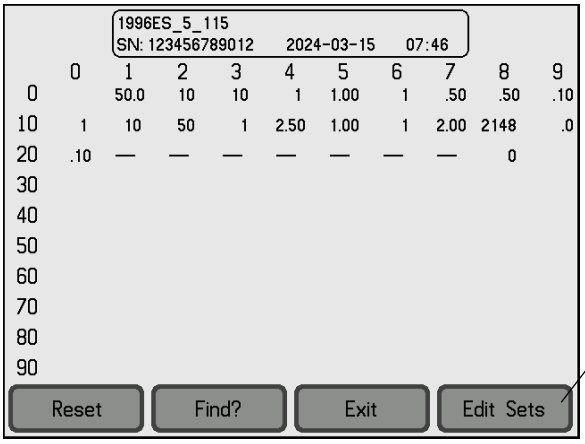


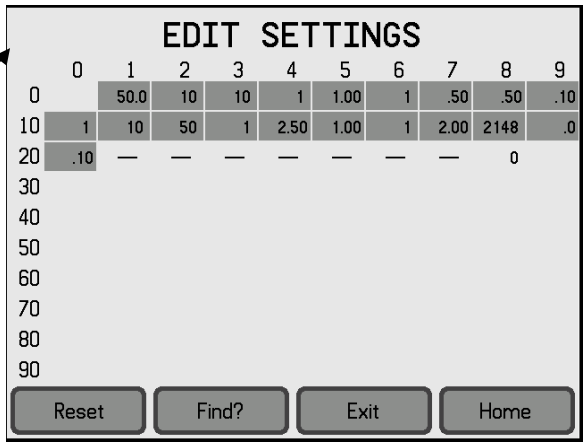
1. **Show All Settings**: Logs all settings of counters on a single page. Always keep a written or photocopy of this screen for future reference
2. **Advanced Settings**: Access to change counters settings
3. **Show All Styles:** Logs all styles on a single screen. Always keep a written or photocopy of this screen for future reference
4. **Advanced Setup**: Provides access to manually cycle assemblies or air cylinders within the machine
5. **Advanced Styles:** This button allows access the list of style buttons. Pressing the particular style bottom will allow editing or recalling that style
6. **System Information:** This button takes you to a screen that displays various information about the machine, such as: serial number or software revision number.
7. **Security** Allows you to change your current level of security or change the password for your security level or any level below you. Appropriate security level required.
8. **Advanced Manual:** Provides access to all Input and Output functions.

b. SHOW ALL SETTINGS

Shows the current parameter values being used by the machine. It doesn't show the function, only the value.

NOTE: Before any program or module change, take notes of these values or a picture in case of any program issues.

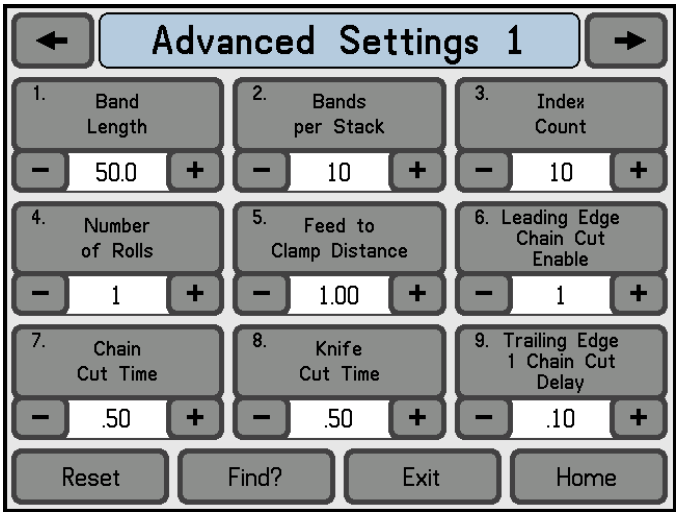




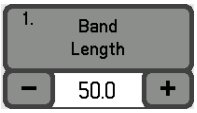
c. ADVANCED SETTINGS

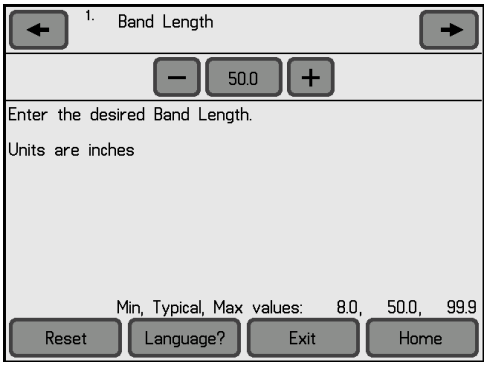
This button selection gives access to all available settings for the machine.
NOTE: All buttons on Advanced Settings screens 1, 2, 3, and 4 take you to individual setting screens that will allow you to adjust the setting and will give a brief description of how the setting works.

1. PAGE 1

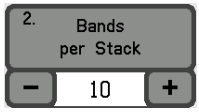


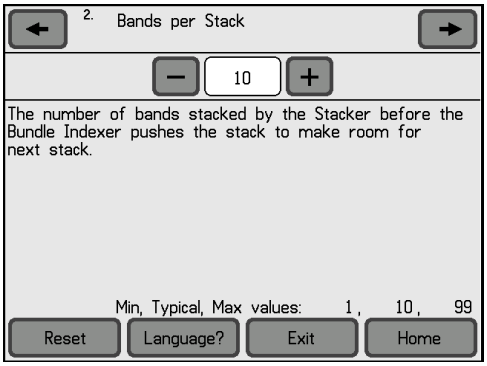
1) Band Length:
Enter the desired Band Length.





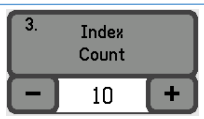
2) Bands per Stack:
The number of bands stacked by the Stacker before the Bundle Indexer pushes the stack to make room for the next stack.

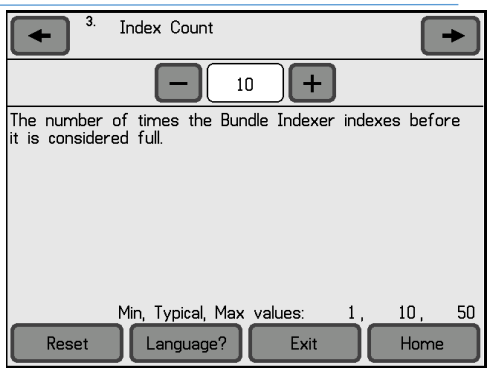




3) Index Count:

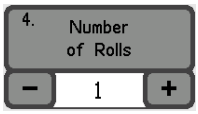
The number of times, Bundle Indexer indexes before it is considered full.

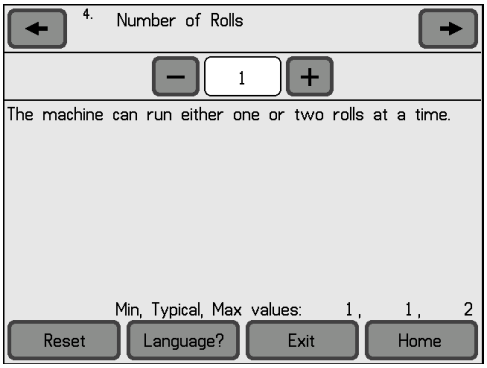




4) Number of Rolls:

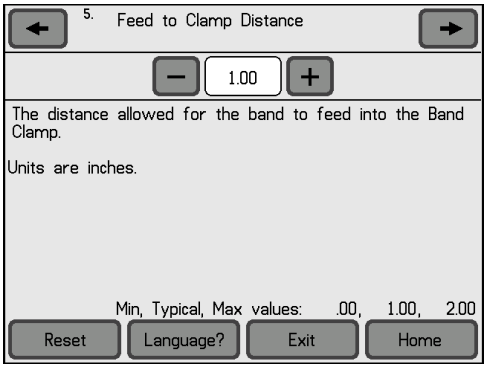
The machine can run either one or two rolls at a time.





5) Feed to Clamp Distance:

The distance allowed for the band to feed into the Band Clamp.

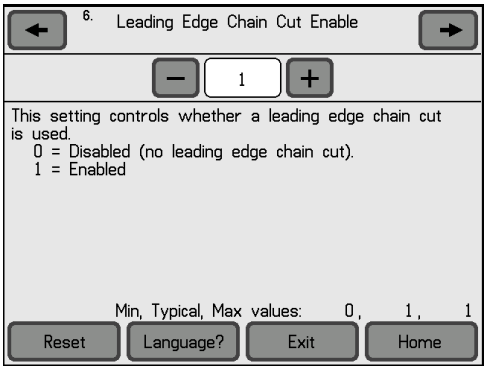


6) Leading Edge Chain Cut Enable:

This setting controls whether a leading-edge chain cut is used.

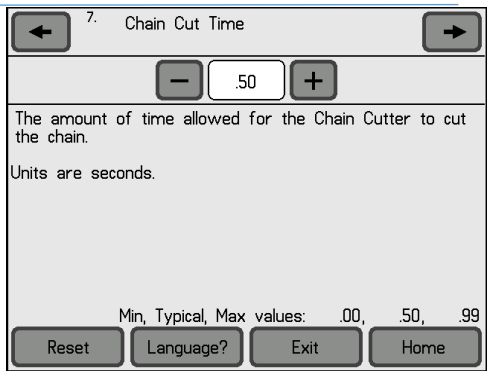
0 = Disabled(no leading-edge cut.

1 = Enabled.



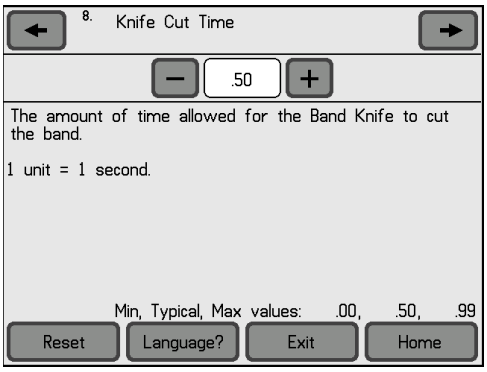
7) Chain Cut Time:

The amount of time allowed for the Chain Cutter to cut the chain. Units are seconds



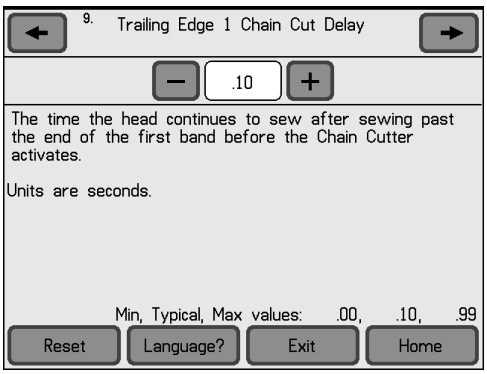
8) Knife Cut Time:

The amount of time allowed for the Band Knife to cut the band. 1 unit = 1 second



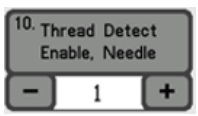
9) Trailing Edge 1, Chain Cut Delay:

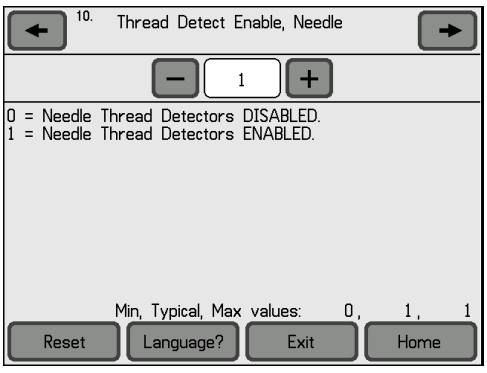
The time, sewing head continues to sew after sewing pas the end of the first band before the Chain Cutter activates. Units are seconds.



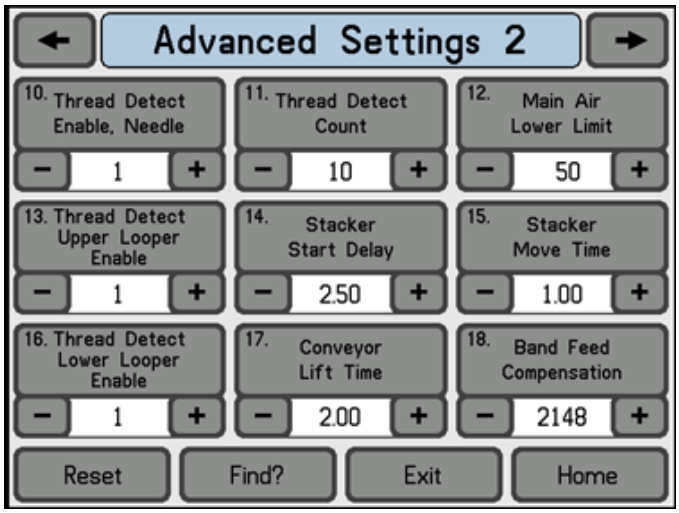
10) Thread Detect Enable, Needle:

0 = Detectors Disabled.
1 = Detectors Enabled.

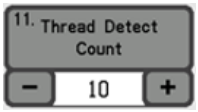




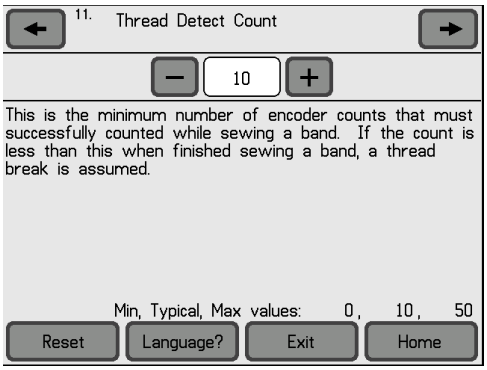
2. PAGE 2



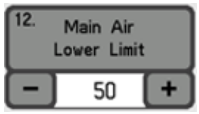
11) Thread Detect Count:



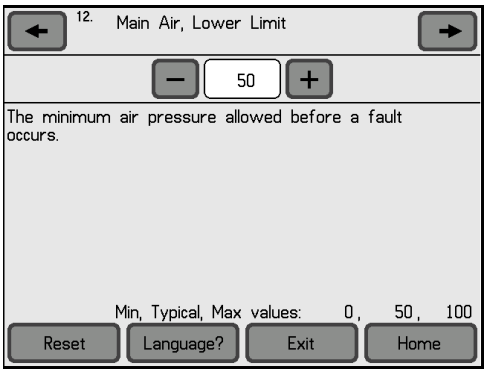
This is the .minimum number of encoder counts that must be successfully counted while sewing a band. If the count is less than this when finished sewing a band, a thread break is assumed.



12) Main Air, Lower Limit:

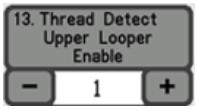


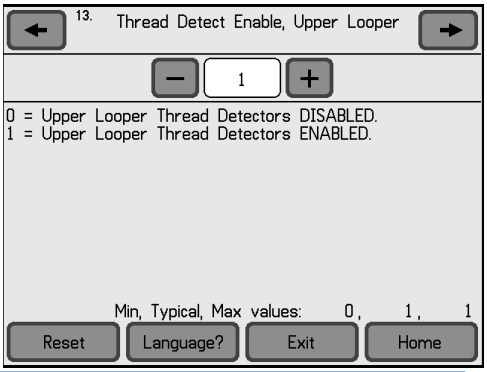
The minimum air pressure allowed before a fault occurs.



13) Thread Detect, Upper Looper:

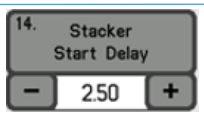
0 = Detectors Disabled.
1 = Detectors Enabled.

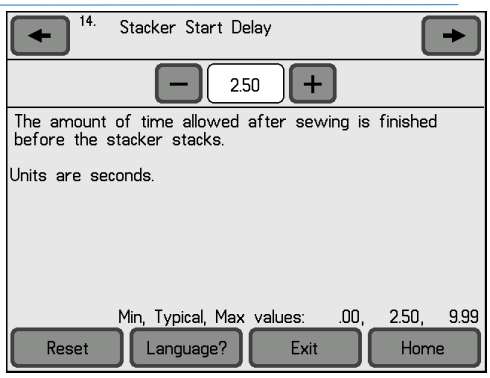




14) Stacker Start Delay:

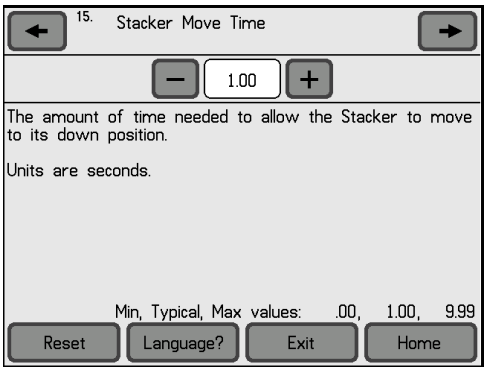
The amount of time allowed after sewing is finished before the stacker stacks. Units are seconds





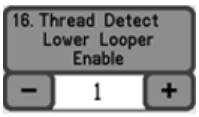
15) Stacker Move Time:

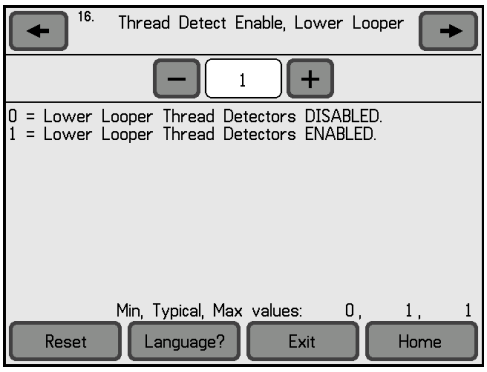
The amount of time needed to allow the Stacker to move to its down position. Units are seconds



16) Thread Detect, Lower Looper

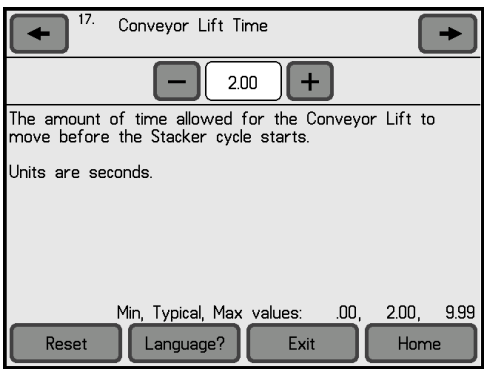
0 = Detectors Disabled.
1 = Detectors Enabled.



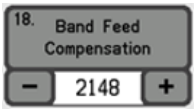


17) Conveyor Lift Time:

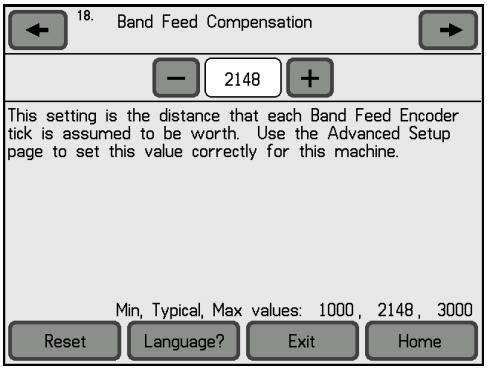
The amount of time allowed for the Conveyor Lift to move before the Stacker cycle starts.



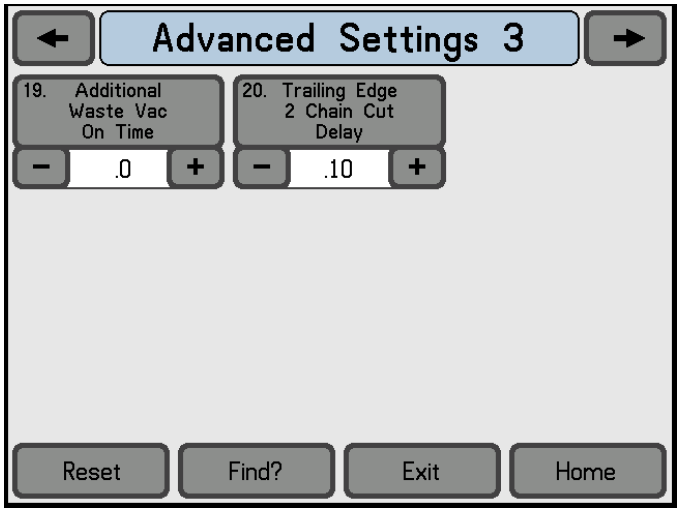
18) Band Feed Compensation :



This setting is the distance that each Band Deed Encoder tick is assumed to be worth. Use the Advanced Setup page to set this value correctly for this machine.



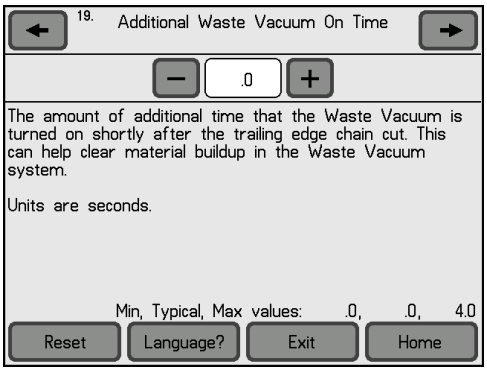
3. PAGE 3



19) Additional Waste Vacuum On Time:

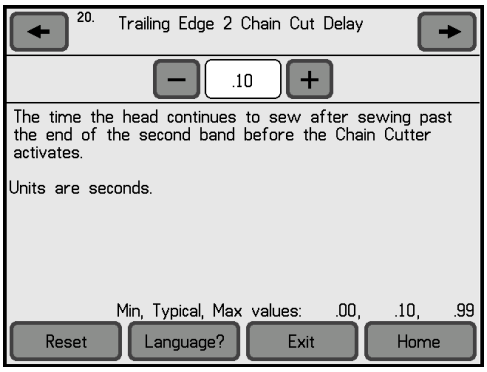
The amount of time that the Waste Vacuum is turned on shortly after the trailing edge chain is cut.

This can help clear material buildup in the Waste Vacuum system



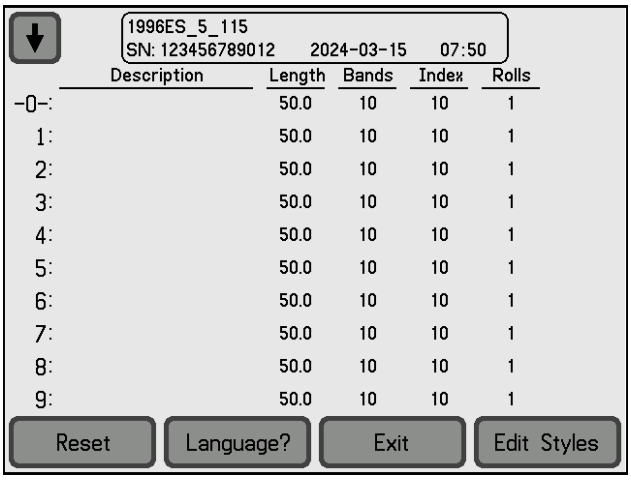
20) Trailing Edge 2, Chain Cut Delay:

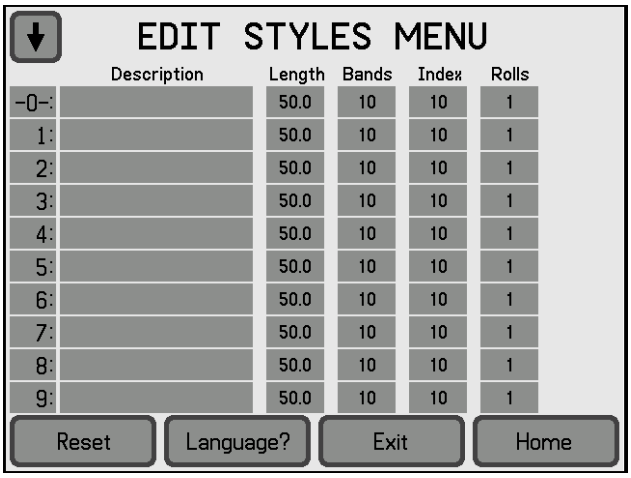
The time the head continues to sew after sewing past the end of the second band before the chain cutter activates.



d. SHOW ALL STYLES

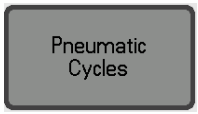
Logs all styles on a single screen, Always keep a written or photocopy of this screen for future reference.

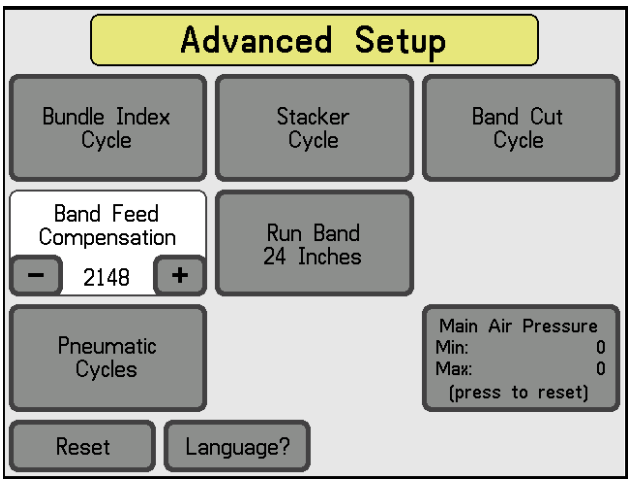


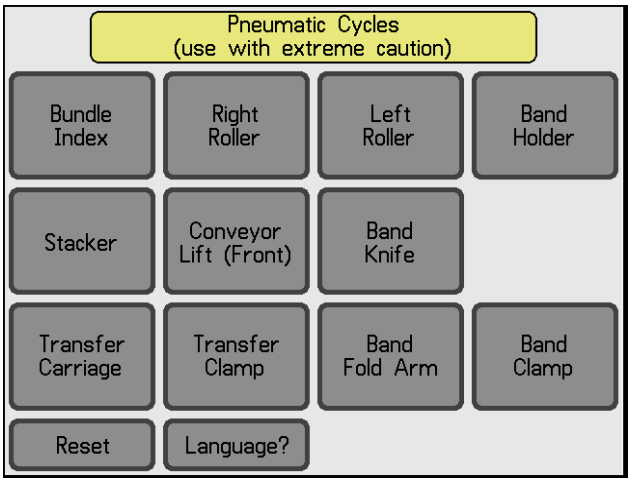


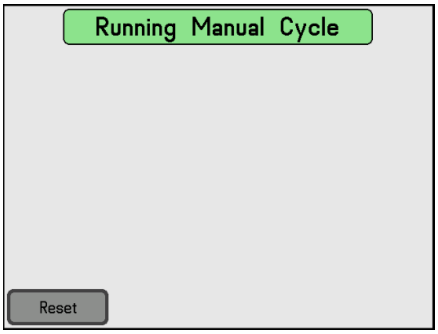
e. ADVANCED SETUP

Manual cycle screens. In this screen the mechanic can manually cycle all Pneumatic cylinders, Stacker, Bundle Index or Band Cut assemblies.

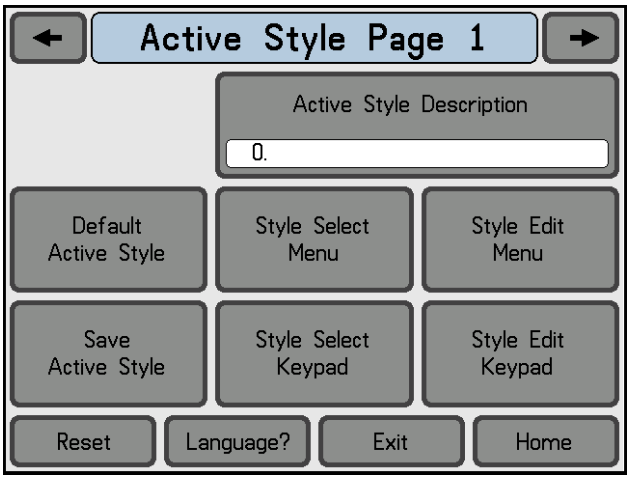


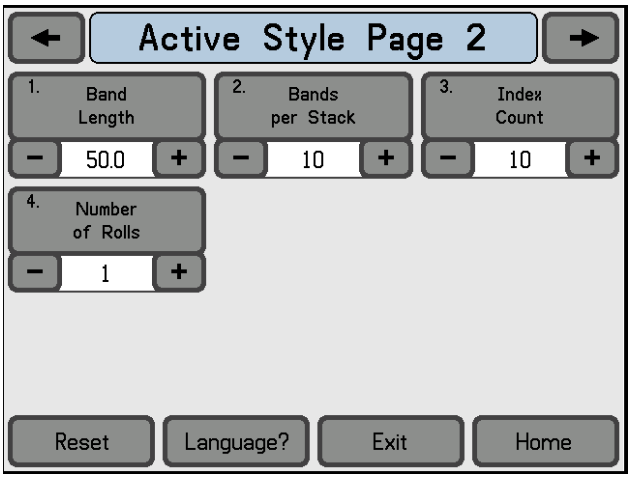






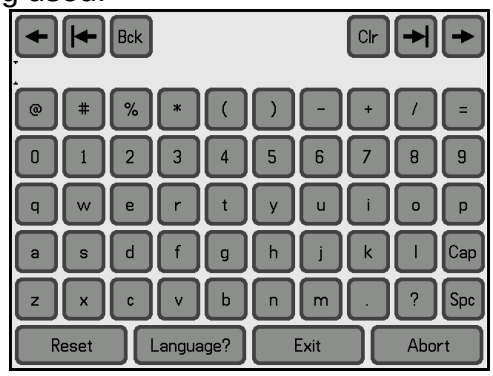
f. ADVANCED STYLES





1. ACTIVE STYLE DESCRIPTION

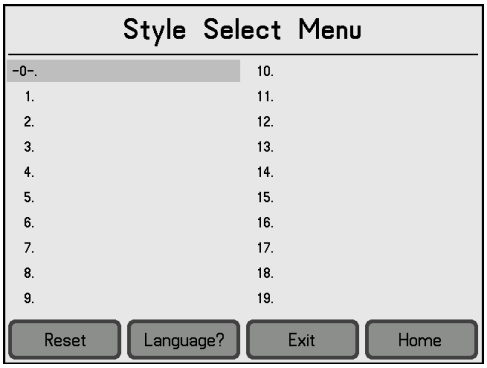
The Active Style Description button shows the current style being used.



2. DEFAULT ACTIVE STYLE

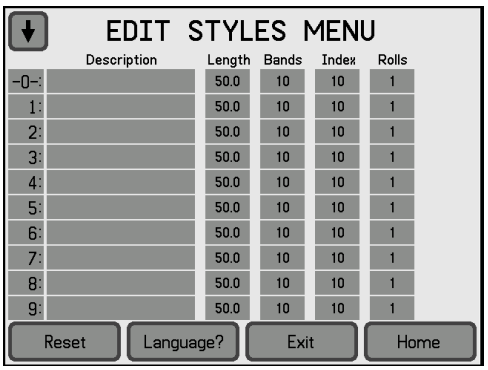
Default Function Only, no Screen required,

3. STYLE SELECT MENU



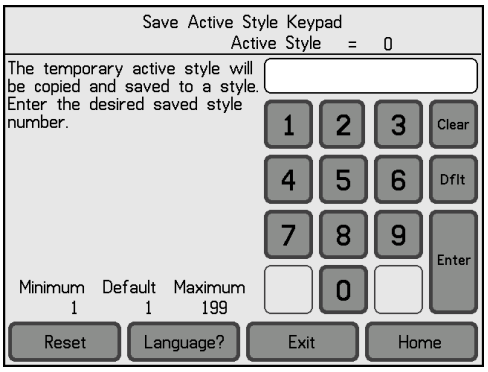
4. STYLE EDIT MENU

Style Edit Menu



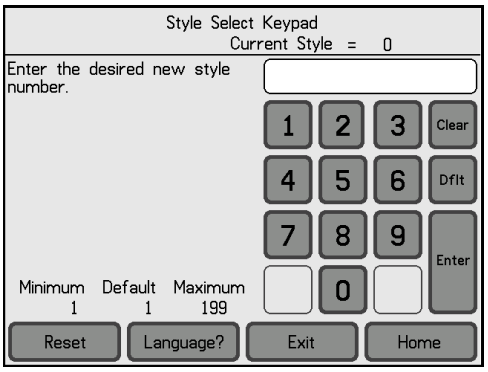
5. SAVE ACTIVE STYLE

Save Active Style



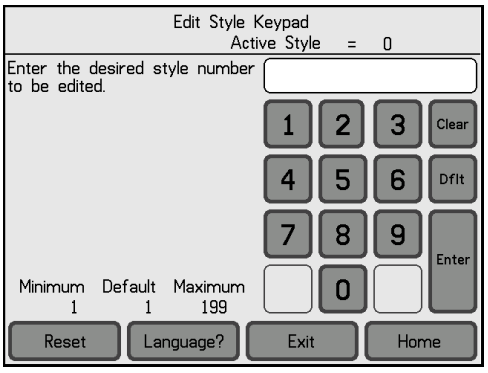
6. STYLE SELECT KEYPAD

Style Select Keypad



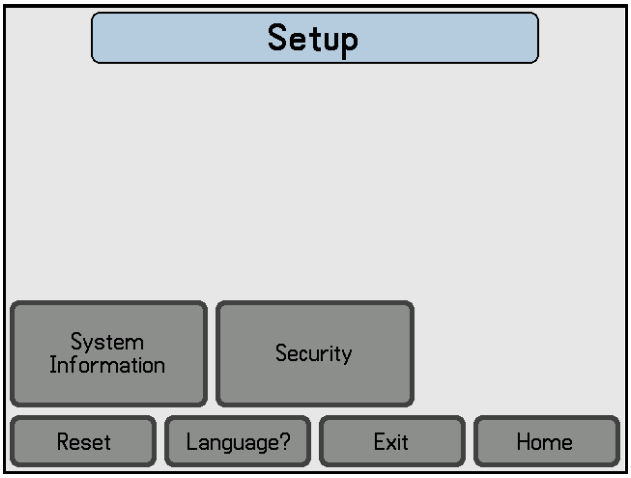
7. STYLE EDIT KEYPAD

Style Edit Keypad

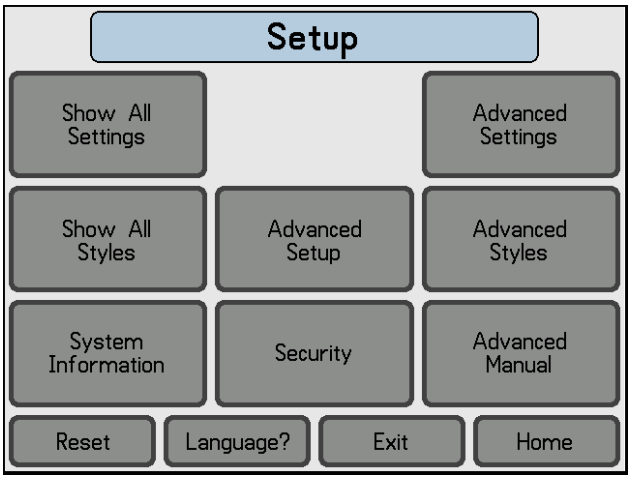


Setup - Continued

Operator Level



Mechanic or Higher Level

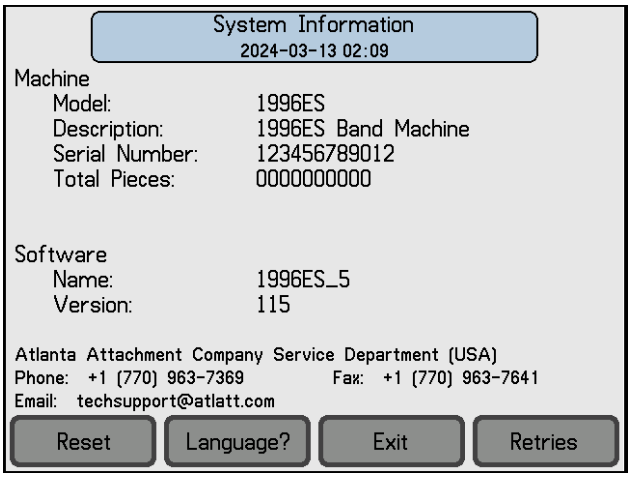


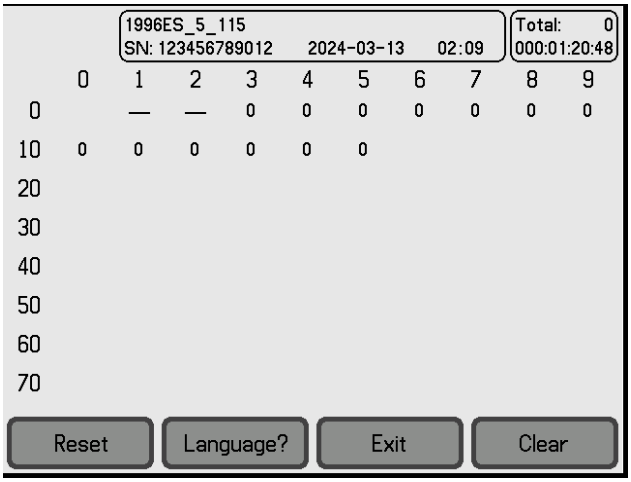
g. SYSTEM INFORMATION

Shows Model, Serial Number, Software Type and Version.

a. Retries Page

Provides troubleshooting information when required to assist when analyzing problems

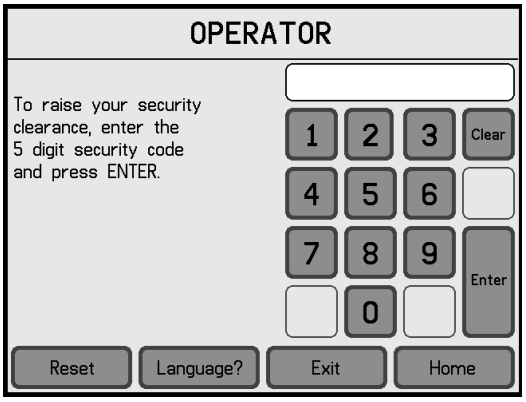




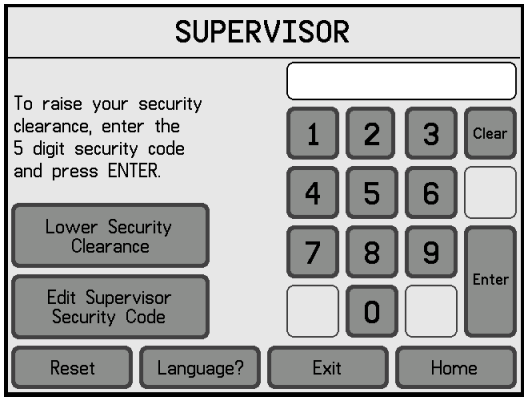
h. SECURITY SCREENS

There are six(6) levels of security, which are accessible with preset or custom codes allowing access to embedded functions of the control system.

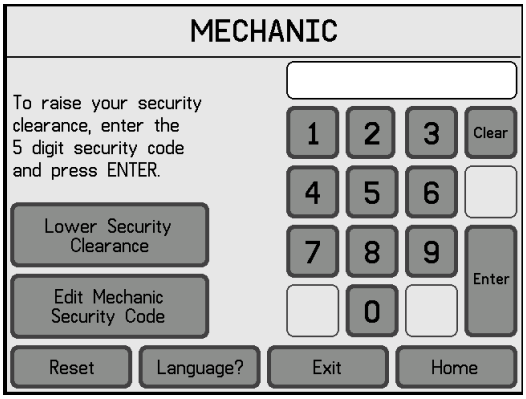
Operator



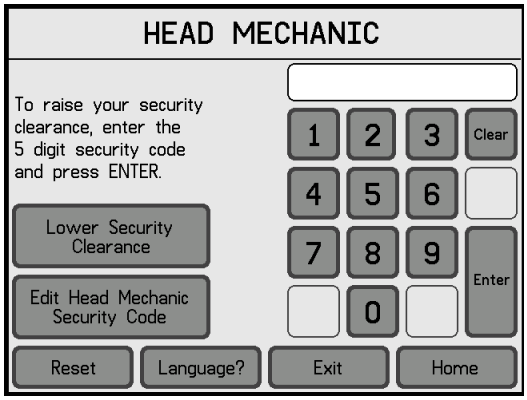
Supervisor



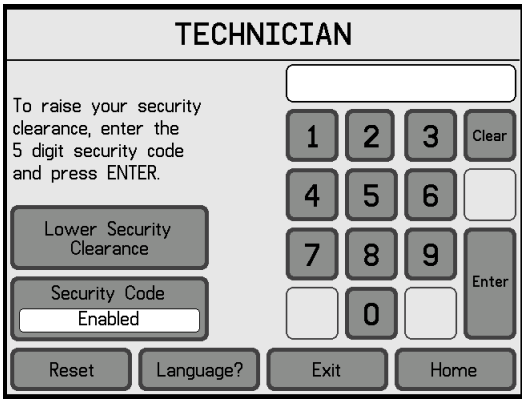
Mechanic



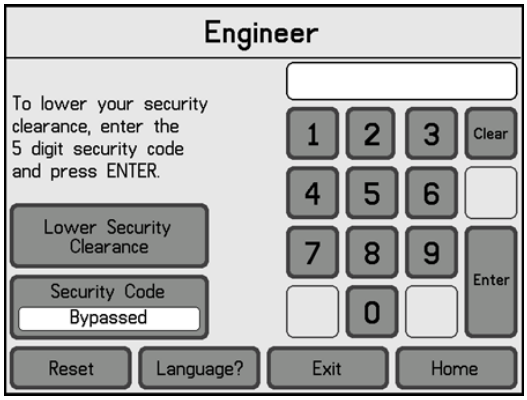
Head Mechanic



Technician

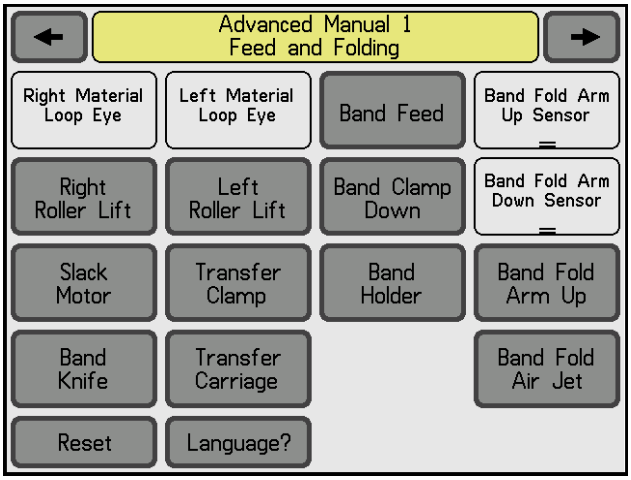


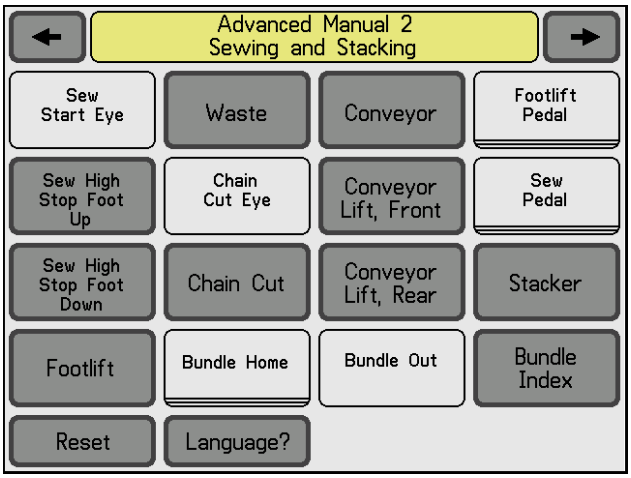
Engineer



i. ADVANCED MANUAL INPUT / OUTPUT TEST

All Dark Colored Buttons on these screens are Output Test buttons that manually activate that particular device or cycle.





All Light-Colored Buttons these screens are Input Test buttons.

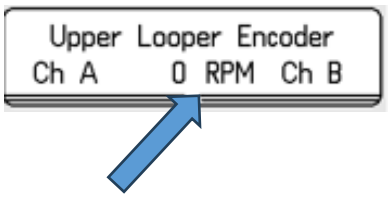
A DOUBLE-LINE will appear or disappear under the Button for a Proximity Sensor, Pedal, Encoder, or Photo Sensor device to denote a change in its state.

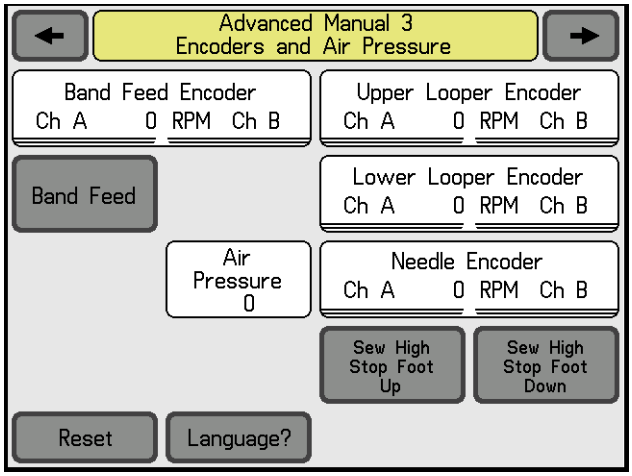
When an eye is covered, a change in state will be shown on the screen. An example is when you manually cover the Photo Sensor a DOUBLE-LINE will appear under the shown button for that Sensor

Inactive

Active

Active





5. Expiration Count 911

Expiration Count Code “911” is not an error that can resolved without assistance from Atlanta Attachment.

- Machine has displayed this error as the result of someone removing or installing modules incorrectly.
- Machine has completed a predetermined time-cycle set by the factory.

When contacting Atlanta Attachment via phone or e-mail, please provide this information below, as displayed on the “911” screen.

- The machine type.
- The machine serial number
- The security key.
- The master clock.

Here is what the 911 warning currently says:

Warning 911 Instructions

1. Contact the Atlanta Attachment Company Service Department (USA).

Phone: +1 (770) 963-7369
Fax: +1 (770) 963-7641
Email: techsupport@atlatt.com

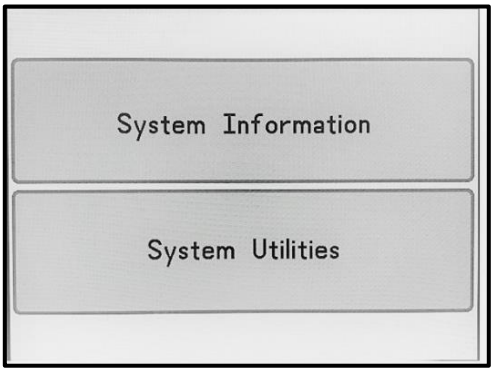
2. Once in contact, provide the following information.

000	Machine Type
000000000000	Machine Serial Number
00000	Security Key
00	Master Clock

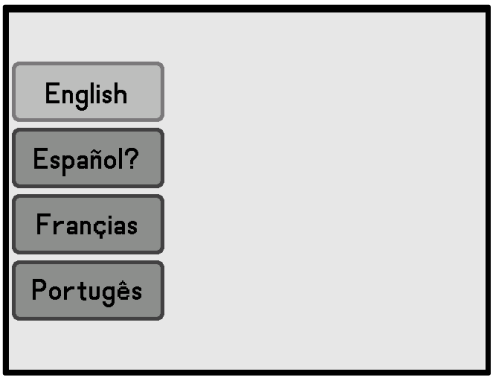
To TEMPORARILY bypass this warning, press CONTINUE

a. Unlock Procedure

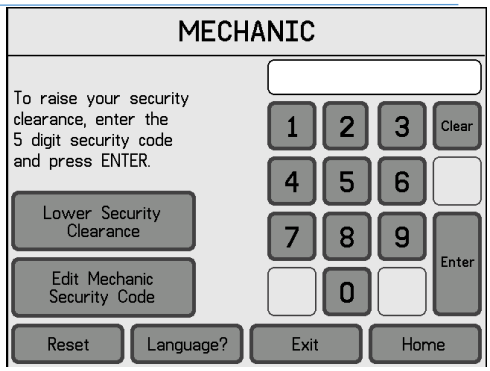
1. As the machine is powering up or after pushing the Reset Button, you must push the System Utilities Button as it becomes visible on the Screen. Note: if you miss the opportunity, push the Reset Button a second time and the process will repeat.



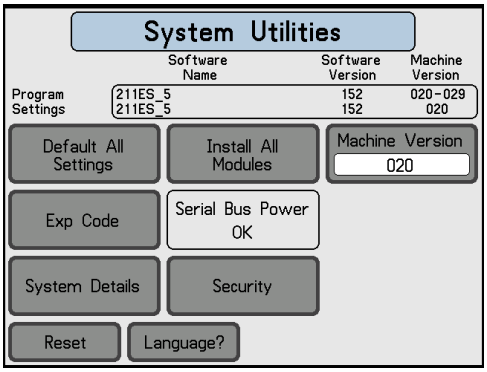
2. Enter your Language preference on the next screen.



3. . Enter your 5-digit Security Code 33333 to Continue

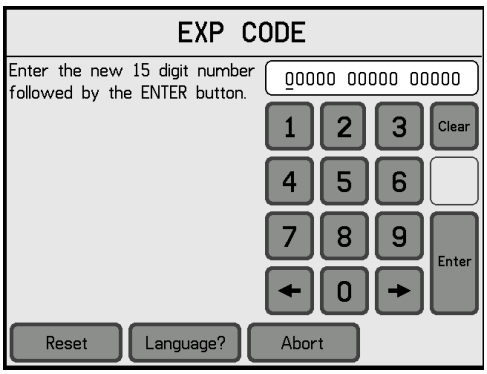


4. When the System Utilities Screen appears, push the EXP Code Button



5. Provide the Information to AAC Service Department and when prompted, push the Keypad Button on the lower right of the screen.

6. Enter the 15-digit number provided and push Enter, the machine reboot and return to the Ready Screen.



4. MAINTENANCE

NOTE: Always wear proper safety equipment when operating or performing maintenance on any equipment.

It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

1. General Safety Instructions

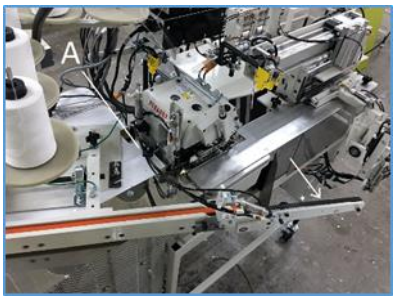
Maintenance should only be performed by trained, qualified personnel. Before performing any maintenance or repair work, switch off the electrical, pneumatic, etc. power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization. Refer to lockout/tag out procedures

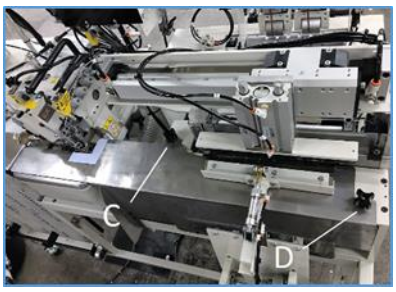
- Always wear proper safety equipment when operating or performing maintenance on any equipment.
- All recommended maintenance is for a single shift schedule; adjust as necessary for a multi-shift operation.
- Equipment should not be used for purposes other than designed or specified.
- The machine shall be switched off, come to a standstill, and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever.
- Use proper lockout/tag out procedures to secure the machine against inadvertent startup.
- Remove any oil, grease, dirt, and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work.
- Do not use any corrosive-cleaning agents.
- Use lint-free rags.
- Retighten all screw connections that have to be loosened for the maintenance and repair work.
- Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work

Preparation

Swing out feed belt and open all machine covers

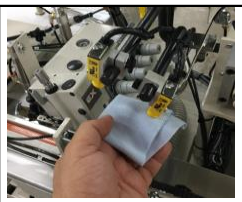
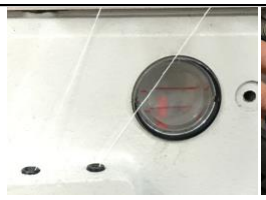
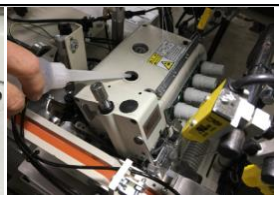
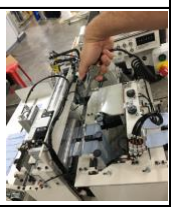
- Release nut “A” and Remove feeding belt from the sewing Area.
- Release Nut “C” & “D” and remove plate
- Open Sewing machine plates “E” & “F”
- Remove all machine covers





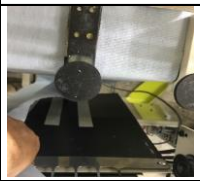
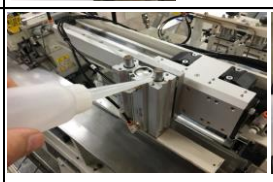
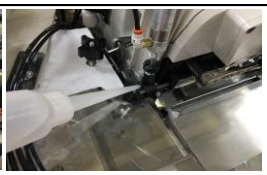
Preventive Maintenance 8 Hrs

		Required Materials
Model:	1996B-ES	Oil can Oil for sewing machine Clean cloth Compressed air
Serial #:		
Operation:	Auto Cuff, Collar, and Waistband	
Sew Head:	Pegasus EX5200	
Serial #:		
Needle:	B-27	

Before starting the day's shift with "The Machine Off"	
Wipe the lenses of all electric eyes and reflective tapes with a clean cloth.	  
Check for liquid waste in the air filter and drain if necessary.	
Check the oil level in the lubrication tank and add if required. Keep level between lines H and L of oil gauge.	 
After a day's shift with "The Machine Off"	
Check for thread accumulation on rollers, pulleys and the moving parts.	 
Open covers, blow out and wipe the machine with a clean cloth, and remove any dirt or tangled threads. Clean sewing motor ventilation.	  
Clean filter on waist container. Dump as necessary.	
Cover the machine and notify the supervisor of any unusual noises or abnormalities that were present during the working shift.	

Preventive Maintenance 40 Hrs

Model:	1996B-ES	**Required Materials**
Serial #:		Oil can
Operation:	Auto Cuff, Collar, and Waistband	Oil for sewing machine
Sew Head:	Pegasus EX5200	Clean cloth
Serial #:		Compressed air
Needle:	B-27	

Open covers, remove needle plate. With an air gun, blow the machine out and remove accumulated dirt in hard to reach areas.	
Check sharpness of edge trimming knives, chain cutter blades, and guillotine blades. Readjust or replace if needed.	 
Check all reflective tape for wear and replace if needed. If tape is replaced, readjust eye sensors.	  
Check all air cylinders for correct operating speed. Adjust flow controls if needed. Check pressure regulator and adjust if needed. Main regulator should be set to 80 psi.	 
Check all mechanical assemblies. Tighten loose components if found. Check for tightness or binding in the assemblies' motion.	
Check tension of all stepping motor belts and sewing motor v-belt, and adjust if necessary.	  
Check for wear and free rotation of feeding belt.	
Add a drop of oil on all moving parts.	 
.- Perform Daily Maintenance	

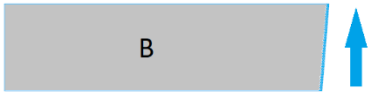
Preventive Maintenance 960 Hrs

Model:	1996B-ES	**Required Materials**
Serial #:		Oil can
Operation:	Auto Cuff, Collar, and Waistband	Oil for sewing machine
Sew Head:	Pegasus EX5200	Clean cloth
Serial #:		Compressed air
Needle:	B-27	

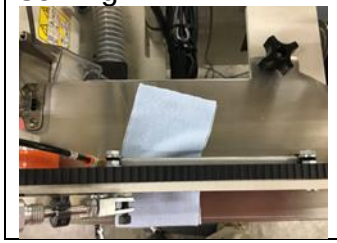
Remove the oil plug and drain the oil from the sewing head. Replace oil and change oil filter.	
Check filter elements in air regulator and replace if necessary.	
Inspect pillow blocks and other non-sealed bearings (conveyors and rotating shafts), and apply one shot of recommended grease to each bearing/fitting.	
Open or remove doors and/or covers to inspect belt(s) for debris or wear, and clean or replace as necessary.	
Remove the guillotine cover on the clamp side. Remove upper blade guide plate. Check the blade side pocket for grease. Add grease if needed.	  

.- Perform Weekly Maintenance

Troubleshooting

Problem	Cause:	Corrective action:
Machine will not start when "Start" button is pressed.	1. In "l Roll" mode, at least one loop eye must be covered. In "2 Roll" mode, both eyes must be covered for the machine to start. 2. The "# Bundles" counter must not be on "0".	1. Check that the band loop detector eyes are covered. 2. Reset if necessary. 3. Press "# BUNDLES" reset button.
Machine stops with band held in clamp. Indicates a "Jam" at the seamer. .	1. The band did not clear the seamer eye in 3 seconds.	1. Check seamer and clear the jammed piece. 2. Check the sew eye for proper operation. Check that the needle guard is not up and covering the eye.
Machine stops, cut band falls from clamp.	1. This indicates a thread break.	1. Check for broken thread. Repair thread and reset the machine 2. Check threading of thread stand and sensors, Sensors must have some tension on the thread to function properly.
Band seam is irregular in shape.	1. Band ends uneven.	1. Adjust flow control on Feed & Cut Assembly. 2. Adjust thumbwheel to align ends evenly.
	1. Seam angles to rear of band.	1. Increase the conveyor speed by adjusting the thumbwheels on the conveyor speed box. 2. Reduce the stitch length. This problem may occur when changing to lighter or limper fabrics that feed faster through the sewing head. 3. Changing the presser foot pressure can also effect this.
	Seam angles to front of band.	1. Decrease conveyor speed by adjusting the thumbwheels. 2. Increase the stitch length. 3. Check band clamp setting. Clamp blade should be set to clamp the band at the end of the band feed stroke. This helps keep the band straight in the conveyor during transfer.
Problem	**Cause:**	**Corrective action:**

Problem	Cause:	Corrective action:
Seam angle varies.	1. The transfer band motion is too fast, causing the band to slip crooked as the front conveyor lowers.	1. Slow the transfer down if necessary. 2. Check the timing of the transfer and front conveyor to ensure that the front conveyor is down and holding the band before the transfer clamp releases it. 3. The band stop may be set too far to the left allowing the band to slip at the end of the transfer stroke.
Transfer, Cut or Stacker is slow or erratic.	1. The air cylinders may be dry. 2. Air pressure may be low.	1. The air should be shut off and a small amount of light machine oil placed in the fitting on each end of the cylinders. Do not use too much oil. 2. Check the air supply pressure while the machine is running and ensure that you maintain at least 60 psi during operation.
Stacker bottoms out in down stroke.	1. Stacker "on"' time is too long for the flow control setting.	1. Readjust the flow controls until the stacker door operates smoothly without bottoming out.
Stacker makes poor stack.	1. Stacker door is too fast or too slow.	1. A fast stacker will cause the band to slide forward and wrinkle. A slow stacker will not have enough speed to flip the top of the band over and it will hang on the stacker door. A stacker adjusted properly will flip the end of the band over flat with little wrinkle.
Band cutter fails to cut band completely.	1. Band is wrinkled under the cutter. 2. The band fold clamp is misadjusted.	1. Adjust band feed flow control so that the bands lie flat as the material is fed. 2. Make sure the feed clamp is down before the band clamp closes. 3. Check spring pressure on knife assembly.
Chain cutter fails to cut chain.	1. Adjustment of chop eye. 2. Chain cutter is jammed or misadjusted.	1. Check adjustment of chop eye. Adjust chop eye position for leading edge cut. 2. Note: Leading edge cut is also the cut between the bands in "2 Roll" mode. 3. Adjust thumbwheel for trailing edge cut. 4. Check knife for mechanical problems or dull blades.

Bands do not position properly in front of the stacker door prior to stacking.	1. Conveyor "Jog"' speed not set properly. 2. Conveyor is not level to the plates.	1. The jog speed of the conveyor determines the positioning of the bands in front of the stacker door. Adjust the speed potentiometer inside the stepping motor drive box to align the bands with the stacker door. 2. Check the conveyor for gaps between the belt and the plates. Reduce the spring pressure on the conveyor arms.
Bands are not straight at the throat plate before sewing. 	1. Conveyor jog speed may be too fast. 2. Oil film, residue or burrs on the cloth plate causing excessive drag on the bands.	1. Decrease the jog speed by adjusting the internal potentiometer in the stepping motor drive box. 2. Clean the cloth plate to remove the residue. 3. Use emery cloth to remove burrs and smooth the plate surface.

1. Efka Controller Error

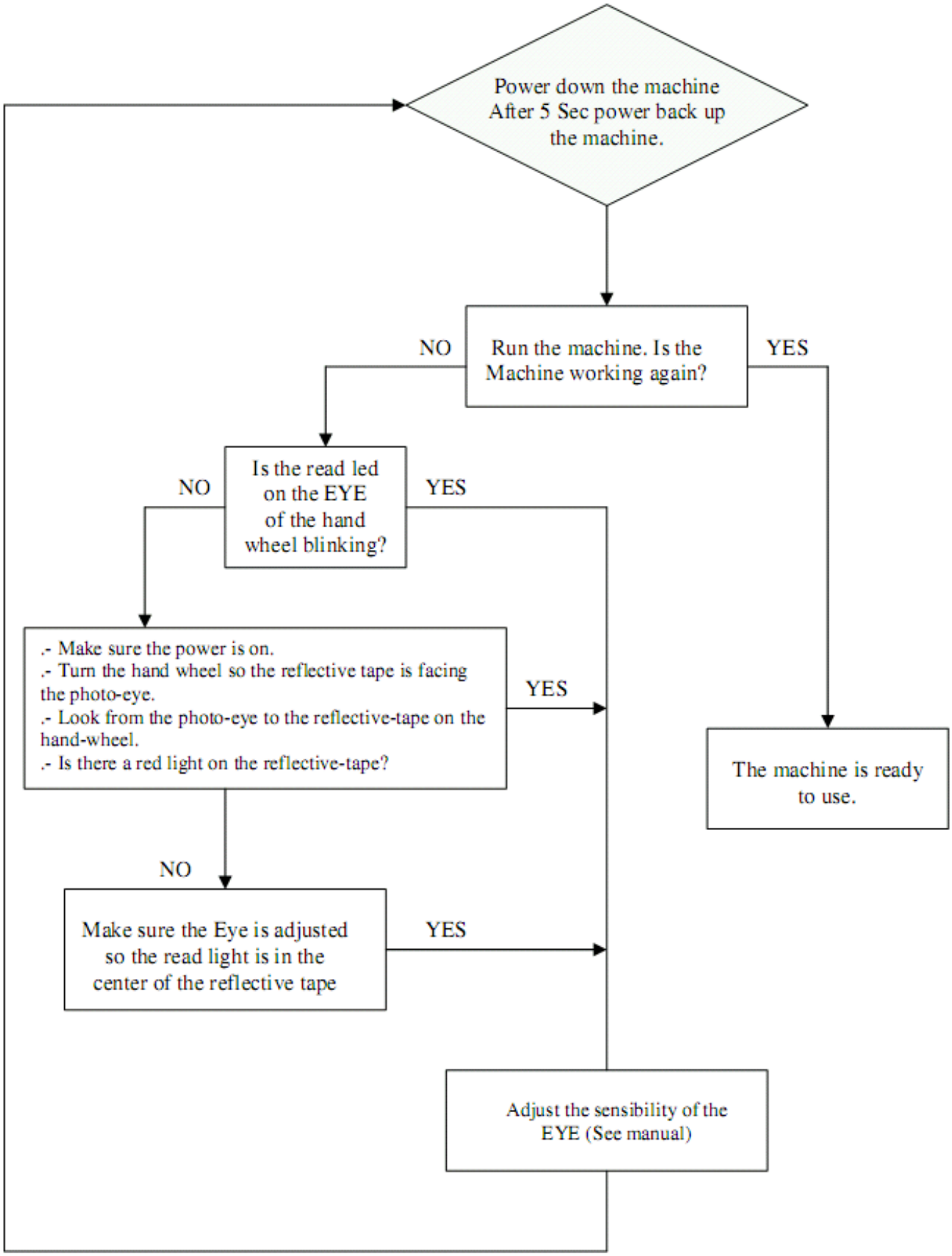
General Information			
On the control	**On the V810**	**On the V820**	**Signification**
A1	InF A1	InF A1	Pedal not in neutral position, when turning the machine on
A2	-StoP- blinking	-StoP- blinking + symbol display	Machine run blockage
A3	InF A3	InF A3	Reference position is not set
A6	InF A6	InF A6	Light barrier monitoring
A7	Symbol blinking	Symbol blinking	Bobbin thread monitor

Programming Functions and Values (Parameters)			
On the control	**On the V810**	**On the V820**	**Signification**
Returns to 000 or to last parameter number	Returns to 0000 or to last parameter number	Like V810 + display InFo F1	Wrong code number or parameter number input

Serious Condition			
On the control	**On the V810**	**On the V820**	**Signification**
E1	InF E1	InF E1	The external pulse encoder e.g. IPG... is defective or not connected.
E2	InF E2	InF E2	Line voltage too low, or time between power off and power on too short.
E3	InF E3	InF E3	Machine blocked or does not reach the desired speed.
E4	InF E4	InF E4	Control disturbed by deficient grounding or loose contact.
E9	InF E9	InF E9	EEPROM defective.

Hardware Disturbance			
On the control	**On the V810**	**On the V820**	**Signification**
H1	InF H1	InF H1	Commutation transmitter cord or frequency converter disturbed.
H2	InF H2	InF H2	Processor disturbed

2. Flow Chart EFKA Error E1



Statement of Warranty

Manufactured Products

Atlanta Attachment Company warrants manufactured products to be free from defects in material and workmanship for a period of eight hundred (800) hours of operation or one hundred (100) days whichever comes first. Atlanta Attachment Company warrants all electrical components of the Serial Bus System to be free from defects in material or workmanship for a period of thirty-six (36) months.

Terms and Conditions:

AAC Limited Warranty becomes effective on the date of shipment.
AAC Warranty claims may be made by telephone, letter, fax or e-mail. All verbal claims must be confirmed in writing.
AAC reserves the right to require the return of all claimed defective parts with a completed warranty claim form.
AAC will, at its option, repair or replace the defective machine and parts upon return to AAC.
AAC reserves the right to make the final decision on all warranty coverage questions.
AAC warranty periods as stated are for eight hundred (800) hours or one hundred (100) days whichever comes first.
AAC guarantees satisfactory operation of the machines on the basis of generally accepted industry standards, contingent upon proper application, installation, and maintenance.
AAC Limited Warranty may not be changed or modified and is not subject to any other warranty expressed or implied by any other agent, dealer, or distributor unless approved in writing by AAC in advance of any claim being filed.

What Is Covered

Electrical components that are not included within the Serial Bus System that fail due to defects in material or workmanship, which are manufactured by AAC are covered for a period of eight hundred (800) hours.
Mechanical parts or components that fail due to defects in material or workmanship, which are manufactured by AAC.
Purchased items (sewing heads, motors, etc.) will be covered by the manufacturers (OEM) warranty.
AAC will assist in the procurement and handling of the manufacturers (OEM) claim.

What Is Not Covered

Parts that fail due to improper usage, lack of proper maintenance, lubrication and/or modification.
Damages caused by; improper freight handling, accidents, fire and issues resulting from unauthorized service and/or personnel, improper electrical, plumbing connections.
Normal wear of machine and parts such as Conveyor belts, "O" rings, gauge parts, cutters, needles, etc.
Machine adjustments related to sewing applications and/or general machine operation.
Charges for field service.
Loss of time, potential revenue, and/or profits.
Personal injury and/or property damage resulting from the operation of this equipment.

5. TRAINING

Activity	Time
SAFETY INSTRUCTION	30 min
INSTALLATION	2 Hr.
OPERATION Emergency Stop ON" Button Stacker Counter Box (Top) Conveyor Speed Box (Middle) Main Control Box (Bottom) Foot lift Pedal Sew Pedal Waste System Stacker Roll Holders Sewing Head Sewing Motor Control Boxes	2 Hr.
PREPARATION Cover Removing. Thread Break Detectors. Threading The Sewing Head. Pre-Sewing Test. Load Rolled Or Festooned Rib Knit Programming The Desired Length Programming The Number Of Pieces Programming The Number Of Bundles Start The Machine Sewing	2 Hr.
Maintenance 8hrs	15 min
SERVICE Lockout/tagout program	5 min
MECHANICAL General Alignment. Conveyor Guillotine Band Fold Clamp Band Clamp Transfer Clamp Stacker Chain Cutter	3 Hr.
PNEUMATIC Air Maintenance Unit FR Pressure Regulator Air Filters Venturi Chain & Trim Waste Flow control panel Solenoid Valve Stack Manifold	2 Hr.

Air Pressure Switch Piece Counter Bundle Counter Air Cylinders Blowers	
ELECTRICAL Ground Main Power Contactor. Stacker Counter Box Programming Instructions Conveyor Speed Box (Middle) JOG button Thumbwheels Potentiometer Jumpers Power Main Control Box (Bottom) Operation Mode AUTO Mode. MANUAL Mode. Other Front Panel Switch Functions Electric Eyes Eye #1 Needle Positioning Eye #2: Leading Edge Eye #3: Trailing Edge Cut Eye #4: Lane 1 Roll Material Eye #5: Lane 2 Roll Material Eye Sensor Adjustment Reflective Tape Maintenance Thread Break Detectors. Needle Thread Sensor Motors Conveyor Stepping Motor Band Feed Stepping Motor Loop Motor Sewing Motor	3 Hrs.
MAINTENANCE Preventive Maintenance 40 Hrs. Preventive Maintenance 960 Hrs.	30 Min
TROUBLESHOOTING	1 Hr.

Participants:

_____

_____

_____

_____

Instructor: _____ **Date:** _____

Notes:

Labels

Piece Counter

QTY./BDL.	BDLS	RESET	RESET	PROG	PROG
CANT/PAQ	PAQUETES	REINICIO	REINICIO	PROGRAMA	PROGRAMA

Stepping Motor

INCREASE NUMBER FOR HIGHER SPEED	JOG	POWER
AUMENTE LOS NUMEROS PARA MAS VELOCIDAD	PRUEBA MANUAL	ENCENDIDO

Main Control Box

AUTO	START	CYCLE STOP COV. JOG	MANUAL
AUTOMATICO	INICIO	PARO DE CICLO MOVER CORREA	MANUAL

CLAMP/ FOLD	CLAMP/ TRANSFER	1 ROLL	FEED BAND
PRENSAR / DOBLAR	PRENSAR /TRASFERIR	1 ROLLO	ALIMENTAR BANDA

CUT BAND	2 ROLL	AIR JETS	STACK
CORTAR BANDA	2 ROLLOS	CHORRO AIRE	APILAR

1, 2 & 3 - BAND LENGTH (XX.X") 4 - ADJ. FEED LGTH. TO CLAMP BAND END (.X') 5 - TRAILING EDGE CHAN LENGTH ADJ. 6 - STACKER ON DELAY	PIECE COUNT
1, 2 & 3 – LARGO DE BANDA (XX.X") 4 - AJUSTE LARGO ALIMEN CON LARGO FIN BANDA 5.- LARGO CADENETA EN FINAL DE COSTURA 6.- DEMORA EN APILADOR	CONTADOR DE PIEZAS

Pedal

SEW	FOOTLIFT
COSER	ELEVAR PRENSATELAS

Standard / Metric Reference chart

	Fractions	1/100	mm		Fractions	1/100	mm		Fractions	1/100	mm		Fractions	1/100	mm
	1/32	0.031	0.79		1 17/32	1.531	38.89		3 1/32	3.031	76.99		4 17/32	4.531	115.09
	1/16	0.063	1.59		1 9/16	1.563	39.69		3 1/16	3.063	77.79		4 9/16	4.563	115.89
	3/32	0.094	2.38		1 19/32	1.594	40.48		3 3/32	3.094	78.58		4 19/32	4.594	116.68
1/8	1/8	0.125	3.18		1 5/8	1.625	41.28		3 1/8	3.125	79.38		4 5/8	4.625	117.48
	5/32	0.156	3.97		1 21/32	1.656	42.07		3 5/32	3.156	80.17		4 21/32	4.656	118.27
	3/16	0.188	4.76		1 11/16	1.688	42.86		3 3/16	3.188	80.96		4 11/16	4.688	119.06
	7/32	0.219	5.56		1 23/32	1.719	43.66		3 7/32	3.219	81.76		4 23/32	4.719	119.86
1/4	1/4	0.250	6.35		1 3/4	1.750	44.45		3 1/4	3.250	82.55		4 3/4	4.750	120.65
	9/32	0.281	7.14		1 25/32	1.781	45.24		3 9/32	3.281	83.34		4 25/32	4.781	121.44
	5/16	0.313	7.94		1 13/16	1.813	46.04		3 5/16	3.313	84.14		4 13/16	4.813	122.24
	11/32	0.344	8.73		1 27/32	1.844	46.83		3 11/32	3.344	84.93		4 27/32	4.844	123.03
3/8	3/8	0.375	9.53		1 7/8	1.875	47.63		3 3/8	3.375	85.73		4 7/8	4.875	123.83
	13/32	0.406	10.32		1 29/32	1.906	48.42		3 13/32	3.406	86.52		4 29/32	4.906	124.62
	7/16	0.438	11.11		1 15/16	1.938	49.21		3 7/16	3.438	87.31		4 15/16	4.938	125.41
	15/32	0.469	11.91		1 31/32	1.969	50.01		3 15/32	3.469	88.11		4 31/32	4.969	126.21
1/2	1/2	0.500	12.70		2	2.000	50.80		3 1/2	3.500	88.90		5	5.000	127.00
	17/32	0.531	13.49		2 1/32	2.031	51.59		3 17/32	3.531	89.69		5 1/32	5.031	127.79
	9/16	0.563	14.29		2 1/16	2.063	52.39		3 9/16	3.563	90.49		5 1/16	5.063	128.59
	19/32	0.594	15.08		2 3/32	2.094	53.18		3 19/32	3.594	91.28		5 3/32	5.094	129.38
5/8	5/8	0.625	15.88		2 1/8	2.125	53.98		3 5/8	3.625	92.08		5 1/8	5.125	130.18
	21/32	0.656	16.67		2 5/32	2.156	54.77		3 21/32	3.656	92.87		5 5/32	5.156	130.97
	11/16	0.688	17.46		2 3/16	2.188	55.56		3 11/16	3.688	93.66		5 3/16	5.188	131.76
	23/32	0.719	18.26		2 7/32	2.219	56.36		3 23/32	3.719	94.46		5 7/32	5.219	132.56
3/4	3/4	0.750	19.05		2 1/4	2.250	57.15		3 3/4	3.750	95.25		5 1/4	5.250	133.35
	25/32	0.781	19.84		2 9/32	2.281	57.94		3 25/32	3.781	96.04		5 9/32	5.281	134.14
	13/16	0.813	20.64		2 5/16	2.313	58.74		3 13/16	3.813	96.84		5 5/16	5.313	134.94
	27/32	0.844	21.43		2 11/32	2.344	59.53		3 27/32	3.844	97.63		5 11/32	5.344	135.73
7/8	7/8	0.875	22.23		2 3/8	2.375	60.33		3 7/8	3.875	98.43		5 3/8	5.375	136.53
	29/32	0.906	23.02		2 13/32	2.406	61.12		3 29/32	3.906	99.22		5 13/32	5.406	137.32
	15/16	0.938	23.81		2 7/16	2.438	61.91		3 15/16	3.938	100.01		5 7/16	5.438	138.11
	31/32	0.969	24.61		2 15/32	2.469	62.71		3 31/32	3.969	100.81		5 15/32	5.469	138.91
1	1	1.000	25.40		2 1/2	2.500	63.50		4	4.000	101.60		5 1/2	5.500	139.70
	1 1/32	1.031	26.19		2 17/32	2.531	64.29		4 1/32	4.031	102.39		5 17/32	5.531	140.49
	1 1/16	1.063	26.99		2 9/16	2.563	65.09		4 1/16	4.063	103.19		5 9/16	5.563	141.29
	1 3/32	1.094	27.78		2 19/32	2.594	65.88		4 3/32	4.094	103.98		5 19/32	5.594	142.08
1 1/8	1 1/8	1.125	28.58		2 5/8	2.625	66.68		4 1/8	4.125	104.78		5 5/8	5.625	142.88
	1 5/32	1.156	29.37		2 21/32	2.656	67.47		4 5/32	4.156	105.57		5 21/32	5.656	143.67
	1 3/16	1.188	30.16		2 11/16	2.688	68.26		4 3/16	4.188	106.36		5 11/16	5.688	144.46
	1 7/32	1.219	30.96		2 23/32	2.719	69.06		4 7/32	4.219	107.16		5 23/32	5.719	145.26
1 1/4	1 1/4	1.250	31.75		2 3/4	2.750	69.85		4 1/4	4.250	107.95		5 3/4	5.750	146.05
	1 9/32	1.281	32.54		2 25/32	2.781	70.64		4 9/32	4.281	108.74		5 25/32	5.781	146.84
	1 5/16	1.313	33.34		2 13/16	2.813	71.44		4 5/16	4.313	109.54		5 13/16	5.813	147.64
	1 11/32	1.344	34.13		2 27/32	2.844	72.23		4 11/32	4.344	110.33		5 27/32	5.844	148.43
1 3/8	1 3/8	1.375	34.93		2 7/8	2.875	73.03		4 3/8	4.375	111.13		5 7/8	5.875	149.23
	1 13/32	1.406	35.72		2 29/32	2.906	73.82		4 13/32	4.406	111.92		5 29/32	5.906	150.02
	1 7/16	1.438	36.51		2 15/16	2.938	74.61		4 7/16	4.438	112.71		5 15/16	5.938	150.81
	1 15/32	1.469	37.31		2 31/32	2.969	75.41		4 15/32	4.469	113.51		5 31/32	5.969	151.61
1 1/2	1 1/2	1.500	38.10		3	3.000	76.20		4 1/2	4.500	114.30		6	6.000	152.40

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